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(54) POLYSULFONE RESIN COMPOSITION AND UTENSIL MADE THEREFROM FOR MEDICAL AND MEDICINAL USE

(57)Abstract:

PURPOSE: To obtain a highly hygienic resin composition by forming a mixture or alloy containing at least one elastomer based on an isobutylene/isoprene copolymer and at least one polysulfone resin.

CONSTITUTION: An isobutylene/isoprene copolymer rubber (referred to as IIR hereinafter), a rubber based on an isobutylene/isoprene copolymer, such as a chlorinated IIR, a polysulfone resin consisting of repeating units represented by the formula (ph-SO<sub>2</sub>-ph-S)<sub>n</sub> (wherein (n) is 2 to 1,000; and ph is phenyl or phenylene), a vulcanizing agent such as sulfur, an organic peroxide or zinc oxide, a vulcanization accelerator, and a processing aid such as microcrystalline wax are mixed each in a prescribed amount. The mixture is kneaded by, e.g. a twin-screw extruder at about 120-380°C to give the objective composition comprising a mixture or alloy containing 99-1wt.% polysulfone resin and 1-99wt.% elastomer based on an isobutylene/isoprene copolymer. This composition is used for utensils for medical and medicinal uses, as a stopper body, an injector, a transfusion set, etc.

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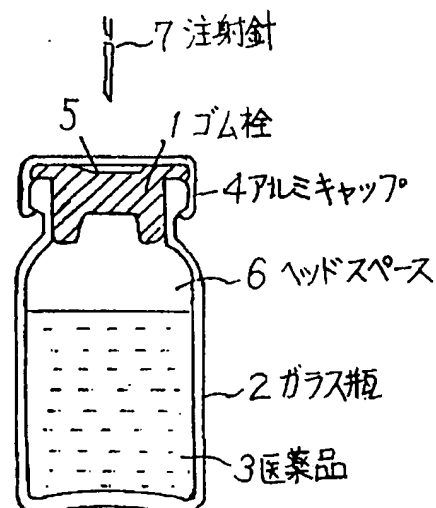
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(54) 【発明の名称】 ポリスルホン系樹脂組成物及びそれよりなる医療用、医薬品用器具

(57) 【要約】

【目的】 医療用、医薬品用として好適な新規な樹脂組成物及びこれからなる医療用、医薬品用器具の提供。

【構成】 イソブチレン-イソプレン共重合系弾性体とポリスルホン系樹脂とを含有してなるポリスルホン系樹脂組成物及びこの組成物からなる医療用、医薬品用器具。衛生性が高く、例えば容器等の器具材料として用いてその内容物の長期保存に好適である。



#### 【特許請求の範囲】

【請求項1】 イソブチレン-イソプレン共重合系弾性体とポリスルホン系樹脂とを含有してなるポリスルホン系樹脂組成物。

【請求項2】 イソブチレン-イソプレン共重合系弾性体の1種以上99～1重量%とポリスルホン系樹脂の1種以上1～99重量%とを含有してなる請求項1記載のポリスルホン系樹脂組成物。

【請求項3】 イソブチレン-イソプレン共重合系弾性体の1種以上とポリスルホン系樹脂の1種以上とを含有してなる混合物又はアロイ化物であることを特徴とする請求項1または請求項2に記載のポリスルホン系樹脂組成物。

【請求項4】 ポリスルホン系樹脂が $(-Ph-SO_2-Ph-S-)_n$ 〔但し $n$ は2～1000の整数を意味する〕を繰り返し単位とするものであることを特徴とする請求項1ないし請求項3のいずれかに記載のポリスルホン系樹脂組成物。

【請求項5】 ポリスルホン系樹脂が $(-Ph-SO_2-Ph-O-)_n$ 〔但し $n$ は2～1000の整数を意味する〕を繰り返し単位とするものであることを特徴とする請求項1ないし請求項4のいずれかに記載のポリスルホン系樹脂組成物。

【請求項6】 イソブチレン-イソプレン共重合系弾性体がイソブチレン-イソプレン共重合ゴム、塩素化イソブチレン-イソプレン共重合ゴム、臭素化イソブチレン-イソプレン共重合ゴム又はイソブチレン-イソプレン-ジビニルベンゼン共重合ゴムを含有することを特徴とする請求項1ないし請求項5のいずれかに記載のポリスルホン系樹脂組成物。

【請求項7】 請求項1ないし請求項6のいずれかに記載のイソブチレン-イソプレン共重合系弾性体とポリスルホン系樹脂とを含有してなるポリスルホン系樹脂組成物よりなる医療用、医薬品用器具。

【請求項8】 医療用、医薬品用器具が栓体であることを特徴とする請求項7記載の医療用、医薬品用器具。

【請求項9】 医療用、医薬品用器具が注射器、輸液セット又は容器であることを特徴とする請求項7記載の医療用、医薬品用器具。

#### 【発明の詳細な説明】

##### 【0001】

【産業上の利用分野】本発明は衛生性が高く、例えば容器等の器具材料として用いてその内容物の長期保存に好適である新規なポリスルホン系樹脂組成物およびこの組成物からなる医療用、医薬品用器具に関する。

##### 【0002】

【従来の技術】医療用、医薬品用器具に関しては薬事法、日本薬局方及び厚生省告示に、その種類、性能、品質、試験項目、試験法、規格値などが定められている。今日のごとく医療技術が日進月歩の時代においては前記

の各項目、方法及び数値にさらに要望事項としての各種規格値を加えた製品が製造されている。

【0003】医療用、医薬品用に用いられる透明な素材は主として硝子製品であり、これに例えば密封するための軟質弾性体として天然ゴムを原料とする成形体を組合わせて器具としてきた。しかし近年は合成樹脂、合成ゴムを医療用、医薬品用器具の素材として検討され市販もされている。

##### 【0004】

【発明が解決しようとする課題】ところで従来汎用されている医療用、医薬品用器具素材については次のような特性と問題点がある。ポリ塩化ビニル（略称PVC）は樹脂に添加される例えば錫系、カドミウム、亜鉛塩複塩化合物などの安定剤や、例えばジオクチルフタレート、ジオクチルアジペート、トリクレジルホスフェートなどの可塑剤などが、医薬品、薬液中に溶出し汚染すること。PVC原料モノマーが樹脂中に残留していることその他に、樹脂製品を廃棄すると環境破壊を起こすことがある。ポリエチレン（略称PE）は軟化点が低い故に、それを素材とする製品は高圧蒸気殺菌できない器具となる。ポリプロピレン（略称PP）は高圧蒸気殺菌はできるが、高温殺菌は困難である。樹脂を変性し透明にして医療用素材とした報告がある（特開平3-163144、同3-28246各号公報）。PE、PPは水分、湿度に対する耐透過性は比較的優れているものの、酸素、炭酸ガス等の気体遮断性が悪く、内容薬物は酸化、変色する問題がある。このようなPE、PPの欠点を改善する方法として、エチレン、酢酸ビニル共重合成分のケン化物（略称EVOH）をPE、PPと混合するか、又はPE、PPとEVOHと積層した包装体にするのが提案されている（例えば「包装フィルム、成形容器、ボトルの実用耐熱性：プラスチックエージ6号（1992年）、「ハイバリア多層プラスチック容器：製薬工場 vol.6, No.12(1986)」、「プラスチックのガスバリア性容器、プラスチックのガスバリア性と容器成形方法：フードパッケージング vol.32-No.3」、「ハイガスバリア性包装材料：プラスチック vol.38, No.5（1987）」、「バリア性樹脂容器への応用と現状：プラスチック vol.1.27, No.5（1977）」、「バリア性複合材料とPVD C：コンパーテック vol.15, No.1（1987）」、「包装材料を機能化するバリア樹脂：コンパーテック vol.17, No.6(1989)」、「最近の機能性包装材料：工業材料 vol.37, No.14(1989)」、「最近の機能性包装容器の動向：科学と工業 vol.61-4(1987)」など）が、EVOHは吸水、吸湿性が極めて強いために高圧蒸気殺菌時に湿度、水分が共存すると、酸素、空気等気体遮断効力が極めて弱いという欠点を有する。硝子素材は耐熱、耐酸素性、透明性などに優れた素材であるが、ガラス表面から発生するアルカリや、硝子から剥離する微粒子が薬品、薬液を汚染するという問題点がある。ポリフェニレンエーテ

ル樹脂（略称PFE）、ポリエチレンテレフタレート（略称PET）、ポリブチレンテレフタレート（略称PBT）、ポリカーボネート（略称PC）の樹脂からは、悪臭、ホルムアルデヒド発生などの問題がある。天然ゴム（略称NR）及び合成ゴムのイソプレンゴム（略称IIR）、ブタジエンゴム（略称BR）、スチレン-ブタジエン共重合ゴム（略称SBR）、ニトリルゴム（略称NBR）、ブチルゴム（略称IIR）及びハロゲン化ブチルゴム（BIIR, CIIR）などは医療用、医薬品用を使用する際に、ゴムを加硫する加硫剤、加硫促進剤及び補強剤が溶出、剥離などを起こして薬品、薬液を汚染する問題点がある。本発明者らは、すでにIIR, BR, SBRに超高分子量のポリエチレンを配合したゴム製品（特公平5-43740号公報）、IIRに特殊な加硫剤を組み合わせたゴム製品（特開平4-213347号公報）を提案している。本発明は、従来品の欠点を解消した新規な素材を用いた医療用、医薬品用器具の提供を目的とするものであり、特に衛生性が高く、容器等の器具に用いて内容物への汚染物質溶出や剥離等がなく内容物の長期保存に適した新規なポリスルホン系樹脂組成物およびそれよりなる医療用、医薬品用器具を意図している。

#### 【0005】

【課題を解決するための手段】本発明は課題を解決するための手段として、イソブチレン-イソブレン共重合系弾性体とポリスルホン系樹脂とを含有してなるポリスルホン系樹脂組成物を提供する。本発明における特に好ましい態様として、イソブチレン-イソブレン共重合系弾性体の1種以上とポリスルホン系樹脂の1種以上とを含有してなる混合物又はアロイ化物であるポリスルホン系樹脂組成物が挙げられる。また本発明における特に好ましい態様として、該ポリスルホン系樹脂が $(-Ph-SO_2-Ph-S-)_n$ 〔但し $n$ は2~1000の整数を意味する〕を繰り返し単位とするもの、あるいは $(-Ph-SO_2-Ph-O-)_n$ 〔但し $n$ は2~1000の整数を意味する〕を繰り返し単位とするもの、であることが挙げられる。本発明は、さらに上記した本発明のイソブチレン-イソブレン共重合系弾性体とポリスルホン系樹脂とを含有してなるポリスルホン系樹脂組成物よりなる医療用、医薬品用器具を提供する。本発明の医療用、医薬品用器具の特に好ましい態様として、栓体が挙げられる。またさらに、本発明の医療用、医薬品用器具が注射器、輸液セット又は容器であることも特に好ましい態様である。

#### 【0006】

【作用】本発明に係るイソブチレン-イソブレン共重合系弾性体（以下、IIR弾性体と略す場合もある）とは、イソブチレン-イソブレン共重合ゴム（IIR）、イソブチレン-イソブレン共重合ゴムに塩素を反応させたゴム（CIIR）、イソブチレン-イソブレン共重合

ゴムに臭素を反応させたゴム（BIIR）、イソブチレン-イソブレン-ジビニルベンゼン共重合ゴム（略称DVIIR）の総称であり、IIR, CIIR, BIIR, DVIIRを加硫剤例えば硫黄、亜鉛華、マグネシウム、アミン化合物、有機過酸化物、マイミド化合物等から選ばれる1種以上を用いて加硫してなる弾性体である。

【0007】本発明に係るIIR弾性体はイソブレン基含有量4.5重量%以下、平均分子量10,000~650,000であり、例えばIIRの100重量部に対して、硫黄、例えば $t$ -ブチルペルオキシイソプロピル、 $n$ -ブチル-4,4'-ビス（ $t$ -ブチルペルオキシド）パレレート、1,1-ジ（ $t$ -ブチルペルオキシ）3,3,5-トリメチルシクロヘキサンなどの有機過酸化物、例えばN,N'- $m$ -フェニレンビスマレイミドなどのマレイミド類、亜鉛華などの加硫剤及び例えばジペンタメチレンチウラムテトラスルフィド、ジエチルジチオカルバミン酸亜鉛、テトラメチルチウラムモノスルフィド、テトラメチルチウラムジスルフィドなどの加硫促進剤を0.5~2重量部加えて例えば加熱加圧することにより加硫する等の公知手段により製造することができる。

【0008】本発明に係るBIIR, CIIRの弾性体は、BIIR, CIIRの100重量部に対して、亜鉛華、酸化マグネシウム、例えば分子内にアミノ基とカルボキシル基とを有する有機アミン化合物等の加硫剤、前記IIR弾性体の場合と同様の加硫促進剤等を1~5重量部添加して加熱、加圧することにより製造できる。

【0009】本発明に係るDVIIRの弾性体は、DVIIR100重量部に対しIIRの弾性体と場合と同様の有機過酸化物を0.5~2重量部配合し、加熱、加圧して加硫することにより製造できる。

【0010】本発明に係る弾性体の加硫、本発明の樹脂組成物の調製及び該組成物からの成形の具体的手法として、生ゴムに上記のような各種配合剤を予め混合した後、インターナルミキサーまたは混合押し出し加工機にて160~220℃にて加圧、加熱する動的なる加硫を行った後に、ポリスルホン樹脂に混合し、又は混合、アロイ化する方法、あるいは加硫剤の他に加硫促進剤を配合しさらにポリスルホン酸を配合し金型内に成形加硫する方法等を採用することができる。

【0011】本発明に係るポリスルホン系樹脂とは、芳香族系炭化水素基とスルホン基 $(-SO_2-)$ との結合を主成分とした超高分子体の樹脂である。該芳香族炭化水素基としてはフェニル基、フェニレン基が挙げられる。スルホン基1個に結合するフェニル基又はフェニレン基は1個の場合と2~7個のものがあり、後者の場合にはビフェニル基、ビスフェニルアルカン基、トリフェニル基などである。また、本発明のポリスルホン系樹脂は構成成分としてフェニル基、フェニレン基又はスルホン基の他に、オキシ基 $(-O-)$ 、チオ基 $(-S$

ー)、カルボニル基(—CO—)、メチル基等の低級アルキル基を有することができる。

【0012】本発明に係るポリスルホン系樹脂の繰返し単位を以下に挙げる。以下の例a～wにおいて、略号は次のとおりを意味する。Ph：フェニル基又はフェニレン基、—SO<sub>2</sub>—：スルホニル基、—O—：オキシ基、—S—：チオ基、—CO—：カルボニル基、CH<sub>3</sub>—：メチル基。n：2～1000の整数

- a：(—Ph—SO<sub>2</sub>—)<sub>n</sub>  
b：(—Ph—SO<sub>2</sub>—Ph—)<sub>n</sub>  
c：(—Ph—SO<sub>2</sub>—Ph—Ph—SO<sub>2</sub>—Ph)<sub>n</sub>  
d：(—Ph—SO<sub>2</sub>—Ph—Ph—Ph—SO<sub>2</sub>—Ph)<sub>n</sub>  
e：(—Ph—SO<sub>2</sub>—Ph—Ph—Ph—SO<sub>2</sub>—)<sub>n</sub>  
f：(—Ph—SO<sub>2</sub>—Ph—O—)<sub>n</sub>  
g：(—Ph—SO<sub>2</sub>—Ph—SO<sub>2</sub>—Ph—O—)<sub>n</sub>  
h：(—Ph—SO<sub>2</sub>—Ph—SO<sub>2</sub>—Ph—O—Ph—O—)<sub>n</sub>  
i：(—Ph—SO<sub>2</sub>—Ph—Ph—SO<sub>2</sub>—Ph—O—)<sub>n</sub>  
j：(—Ph—SO<sub>2</sub>—Ph—Ph—SO<sub>2</sub>—Ph—O—Ph—O—)<sub>n</sub>  
k：(—Ph—SO<sub>2</sub>—Ph—Ph—SO<sub>2</sub>—Ph—O—Ph—Ph—O—)<sub>n</sub>  
l：(—Ph—SO<sub>2</sub>—Ph—Ph—O—Ph—O—)<sub>n</sub>  
m：(—Ph—SO<sub>2</sub>—Ph—O—Ph—O—Ph—O—)<sub>n</sub>  
n：(—Ph—SO<sub>2</sub>—Ph—O—Ph—Ph—O—)<sub>n</sub>  
o：(—Ph—SO<sub>2</sub>—Ph—CH<sub>2</sub>—Ph—SO<sub>2</sub>—Ph—O—)<sub>n</sub>  
p：[—Ph—SO<sub>2</sub>—Ph—Ph—O—Ph—C(CH<sub>3</sub>)<sub>2</sub>—(CH<sub>3</sub>)—Ph—O—]<sub>n</sub>  
q：[—Ph—SO<sub>2</sub>—Ph—O—Ph—C(Ph)(Ph)—Ph—O—]<sub>n</sub>  
r：(—Ph—SO<sub>2</sub>—Ph—S—)<sub>n</sub>  
s：(—Ph—SO<sub>2</sub>—Ph—O—Ph—CO—Ph—O—)<sub>n</sub>  
t：(—Ph—SO<sub>2</sub>—Ph—O—Ph—O—)<sub>n</sub>  
u：[—Ph—SO<sub>2</sub>—Ph—O—Ph—C(CH<sub>3</sub>)<sub>2</sub>—(CH<sub>3</sub>)—Ph—O—]<sub>n</sub>  
v：(—Ph—Ph—SO<sub>2</sub>—Ph—Ph—SO<sub>2</sub>—Ph—O—)<sub>n</sub>  
w：[—(CH<sub>3</sub>)<sub>2</sub>—(CH<sub>3</sub>)—Ph—SO<sub>2</sub>—Ph—(CH<sub>3</sub>)<sub>2</sub>—(CH<sub>3</sub>)—O—Ph—CO—Ph—O—]<sub>n</sub>

【0013】本発明に係るポリスルホン系樹脂は前記したような繰返し単位を主成分とする重合体であり、従

来公知の技術、例えば特公昭45-21318、同46-21458、同47-617、同53-25879、同56-2091、同61-12930、特開昭52-96700、同53-10696、同59-12930、同63-21030、同63-243128、特開平1-315422、同1-318040、同3-41120、同3-95200、同4-335030、同5-9453各号公報等に記載される技術により重合して製造できる。該ポリスルホン系樹脂の平均分子量は5,000～950,000であり、該樹脂は極性有機溶媒中でアルカリ性触媒を使用して重合すること方法が多く採用されている。ただし本発明に使用するポリスルホン系樹脂は、溶媒洗浄、温水洗浄などを繰返して、原料化合物、低分子量のオリゴマー、無機化合物(多くはNaCl)等をできるだけ除去したものが好ましい。このような該ポリスルホン系樹脂の精製手段には各種の公知技術を適用できる。本発明に係るポリスルホン系樹脂は強靱性、高強度、耐熱性、耐クレープ性、耐摩耗性であり、淡白色、透明性の樹脂であって、酸、アルカリ、塩溶液にも優れた耐性を有し、洗剤、炭化水素中での高温条件にも耐え得る。さらに、耐スチーム、耐熱水性で130℃、30分間のオートクレープ滅菌にも繰返し耐え得る特性を有するので、医療用、医薬品用器具に利用して非常に有利である。

【0014】なお、本発明のポリスルホン系樹脂としては比較的高分子量の安定剤を添加したものが好ましい。このような安定剤としては、例えばテトラキス[メチレン(3,5-ジ-tert-ブチル-4-ヒドロキシフェニル)プロピオネート]メタン：商品名イルガノックス1010(チバガイギー(株)製)、トリエチレングリコールビス(2-(2-tert-ブチル-4-ヒドロキシ-5-メチルフェニル)プロピオネート)：商品名イルガノックス245(チバガイギー(株)製)、ビス(2,6-ジ-tert-ブチル-4-メチルフェニル)ペンタエリス-トールジホスファイト：商品名アデオスタブPEP-36(旭電化(株)製)、N,N'-m-フェニレンビスマレイミド、トコフェロールなどが挙げられ、これらの1種類以上を該ポリスルホン系樹脂100重量部に対し0.01～0.5重量部添加することが好ましい。

【0015】本発明の組成物は上記したIIR弾性体とポリスルホン系樹脂を含有してなる。また、該IIR弾性体とポリスルホン系樹脂は各々1種以上を配合することもできる。IIR弾性体に対しポリスルホン系樹脂を99～1重量%、好ましくは95～5重量%の範囲で配合する。この配合割合は医療用、医薬品用器具の種類、その器具に適する硬軟の度合いに対応して選択することが望ましい。例えば医療用、医薬品用器具栓体として適用する場合には、IIR弾性体100重量部に対し、ポリスルホン系樹脂を5～40重量部配合することが好ましい。特に好ましくは5～30重量部である。

これは5重量部未満では所期の目的に対し好適な特性例えば弾性を得られず、40重量部を越えると栓体としての物理的特性、例えば注射針刺しの際に必要なとされる物理的特性を欠くことになるからである。また、医療用、医薬品用器具の容器本体等を使用する場合には、ポリスルホン酸100重量部に対してB I I R, C I I R, D V I I Rから選ばれる弾性体を2~100重量部、好ましくは5~50重量部を混合、又はアロイ化する。耐熱性、高弾性の樹脂体となり、医療用器具、医薬品用器具として耐熱性が高く、従って熱殺菌、高圧オートクレブ殺菌、エチレンオキシド殺菌を繰り返し行い得る容器、器具となる。従って、手術用器具、注射器、注射器兼容器等に成形して好適である。またフィルムにして輸液用袋類等の素材に用いることができ、ブドウ糖、アミノ酸を含有する高タロリー輸液剤の保存容器などにも好適に用い得ることが判明した。該フィルム成形の場合には本発明の組成物に加工助剤、グラフト共重合体等を混合することが好ましい。

【0016】前述のように本発明のI I R弾性体とポリスルホン樹脂からなる組成物は混合物であってもよいし、アロイ化物とすることもできる。また、混合物、アロイ化物の加工性、成形性を良好にするために加工助剤を添加することができる。このような加工助剤としては、例えば高級脂肪酸類：例えばアラキシン酸、ベヘン酸等、金属石ケン類：例えばステアリン酸亜鉛、ステアリン酸カルシウム、ステアリン酸アルミニウム塩など、脂肪酸アミド類：例えばステレンビスステアリルアミド、エチレンビスオレイン酸アミド、ベヘン酸アミド、ステアリン酸アミドなど、高級脂肪酸エステル類：例えば炭素数20~24個の長鎖脂肪酸エステル、ソルビタン脂肪酸エステルなど、ワックス類：例えばマイクロクリスタリンワックス、ポリエチレンワックスなど、高分子量ポリエチレン類、炭素数16~18個のアルコール類、シリコンオイル類等の1種類以上を10重量部以下、グラフト共重合体、ブロック共重合体（例えば、ブタジエーン-スチレン-ブロック共重合体及び該共重合体の水素添加物、ポリジメチルシロキサン-ポリエチレンオキシドブロック共重合体、エチレン-グリシジルメタクリレートグラフト共重合体など）などから選ばれる1種類以上を20重量部以下配合することによって非常に均一なアロイ化物とすることができ、加工性を改善することができる。

【0017】本発明に係るI I R弾性体とポリスルホン系樹脂とを混合、混練してアロイ化する方法としては、従来公知の装置、例えばインターナルミキサー、一軸又

は二軸押出機を用いて、温度120~380℃にて行なうことができ、均一な混合物、アロイ化物となる。また、そのまま押出成形して医療用、医薬品用器具とすることもできる。本発明に係る医療用、医薬品用器具として成形した製品は、いずれも日本薬局方（第12改正）の48. 輸液用ゴム栓試験法、49. 輸液用プラスチック容器試験法、厚生省告示第301号、同413号、同442号に適合する医療用、医薬品用器具であり、注射器、注射器兼容器、輸液セット器具とすることができる。また医薬品、薬液の容器として内容薬品を長期に渡りその品質を保持し得るという優れた特徴を有する容器となる。

#### 【0018】

【実施例】以下、本発明を実施例により詳細に説明するが、本発明はこれらに限定されるものではない。

【ポリスルホン酸の重合：1】10,000mlのオートクレブにNaHS（濃度47重量%）358g、NaOH（濃度48重量%）225g、CH<sub>3</sub>COONa123g、Na<sub>2</sub>CO<sub>3</sub>19g及びN-メチルピロリドン2376gを仕込み、窒素ガスを流しつつ温度130℃にて3時間攪拌する。その混合物を70℃に冷却した後に、該反応物中にN-メチルピロリドン297gと4,4-ジクロロジフェニルスルホン878.5gとの混合物を攪拌しつつ混入し、温度260℃にて4時間加熱して重合を行なう。次に1℃/分の速さにて120℃まで攪拌しつつ冷却し、酢酸9gとN-メチルピロリドン2583gの中に攪拌しつつ徐々に流し込み、重合体を微粒子粉末状として析出せしめ、濾別した後に70℃の温水1500mlにて洗浄、さらにメタノール1000mlにて洗浄する。得られた重合体100重量部にイルガノックス1010

0.1重量部を添加後、真空にて乾燥する。得られた樹脂量632g、ガラス転移温度192℃であった。該樹脂は淡黄色透明で、繰り返し単位は(-Ph-SO<sub>2</sub>-Ph-S-)n、すなわち前記した繰り返し単位rであった。該樹脂を樹脂rと略す。

【0019】【実施例1~3及び比較例1,2】I I R〔商品名 JSR Butyl 365、日本合成ゴム（株）製、不飽和度2.0モル%、ML<sub>1+8</sub> 100℃ 42〕100重量部に対して、前記で得たポリスルホン樹脂rを下記の表1に示す比率（表中の部は重量部を意味する）で配合し、インターナルミキサー、二軸押出機にて混練し、二本ロールにて分出して配合生地を作成した。

#### 【0020】

##### 【表1】

配 合	実施例 1	実施例 2	実施例 3	比較例 1	比較例 2
IIR 樹脂 r	100 部 5	100 部 2.5	100 部 5	100 部 ① 10	100 部 ② 25
加硫剤 ③	1.5	1.5	1.5	1.5	1.5
加硫促進剤 ④	2	2	2	2	2
ワックス ⑤	3	3	3	3	3
⑥	—	—	1	—	—

【0021】上記表1の①～⑥は次の通り。

①PE：低密度ポリエチレン、ショウレックスM22

2、昭和電工（株）製、軟化点92℃。

②充填剤：商品名 Whitetex：Southern Clay社製。

③2，5－ジメチル－2，5－ジ（ｔ－ブチルペルオキシ）ヘキサン。

④N，N'－m－フェニレンビスマレイミド。

⑤マイクロクリスタリンワックス（融点110° F、日本精蠟（株）製）。

⑥γ－メルカプトトリメトキシシラン：日本ユニカー製 A－189（商品名）。

【0022】上記で得た配合生地をオシレイティング・

ディスクレオメーター（O. R. R. と略称する）試験機で、日本ゴム協会誌VOL. 40（1967）p874、ASTM D－2705、SRIS 3102 により振動式加硫試験〔回転往復運動の微小角振動（ねじり振動）を与えて、その対応する応力をトルク値として測定し、トルク最高値（c）を求め、これとトルク最低値（b）との差を求める〕を行い、その結果を表2にまとめて示す。

【0023】

【表2】

	項 目	実施例 1	実施例 2	実施例 3	比較例 1	比較例 2
試 験 結 果	スコッチ時間（分）	3.0	3.1	3.0	2.9	2.6
	加硫時間（分）	8.9	9.3	8.8	8.9	8.5
	トルク値 （kg/cm）	最低値（b）	9.6	10.1	9.4	8.8
		最高値（c）	21.8	23.5	22.5	16.3
		（c）－（b）	12.2	13.4	13.1	7.5
	加硫ゴム片のカタサ(Hs)	35	40	38	24	28

【0024】表2に示す如く、実施例1は比較例1，比較例2の生地よりもトルク値〔（c）－（b）〕の差が大きく、カタサも大きいのでゴムが高弾性体であることがわかる。また樹脂Aを増量した実施例2、シランカップリング剤を添加した実施例3では、それぞれその添加効果により実施例1よりも高いトルク値とHs値を示している。

【0025】次に上記で得た各生地を用いて、図1に示す医薬品用ゴム栓を加硫条件：温度170℃、10分間：で成形した。なお、図1は該ゴム栓をガラス瓶に適用した一具体例の概略断面図でありガラス瓶2にゴム栓1を打栓してアルミキャップ4で巻き締めた状態を示し、3は医薬品、5は針入部、6はヘッドスペース、7は注射針を示す。各ゴム栓について第12改正日本薬局

方の試験法及び、本発明者らが実用している特殊な衛生試験を行った。その結果を表3及び表4に示す。特殊な衛生試験は次のように行なう。

【0026】その他の特殊な衛生試験

微粒子量（ゴム栓より発生する粒子量の試験）；硬質ガラス瓶中にゴム栓10個を入れ、無塵水300ml加えて、容器口をフィルムで包み、手にて2回転／秒程度にて20秒間振動する。その後1時間静置してから光遮蔽型自動微粒子計測器（H I A C社製）にて水中の微粒子の個数を測定する。なお、注射液中の5μm以上の微粒子の存在は血管を閉塞する等の問題を起こすので重要項目となっている。

【0027】ゴム破片の剥離（Fragmentation）；図1に2として示す形状の瓶（10ml容量）に



水5mlを入れ、ゴム栓1を打栓し、次にアルミキャップ4を巻き締める。試験針〔22G(0.70×32mm)〕を付けた注射筒に2mlの水を入れ、これをゴム栓の針入部5に20回貫通させる。20回目の貫通時に注射筒内の水を瓶内に注入した後注射針を引き抜く。瓶内を振動したのち、ゴム栓を取り除き、内容液をろ過し、濾紙上のゴム片個数を数える。本試験法は、ブリティッシュスタンダード3263(BSと略す)の方法を改良したもので、BSの規格はゴム片3個以下であるが、現在当該業界では2個以内が要望されている。

【0028】薬液漏れ；図1の瓶2に水500mlを入れ、ゴム栓1を打栓し、アルミキャップ4を巻き締める。これを容器内にて121℃に30分間加熱した後、ゴム栓の針入部5よりロケット針7(JMS性200号、輸液セット付ロケット針)を刺し通し、瓶を倒立状態に保ちながら1時間放置し、次に空気針を刺し、瓶内の水を400ml流出せしめ、この時点でゴム栓からロケット針を引抜き、このときの液漏れ(ml)を観察、測定する。

【0029】撥水性(Water repellency)；図1の瓶2に蒸留水500mlを入れ、ゴム栓1を打栓し、アルミキャップ4を巻き締める。次に耐圧加熱容器に入れ、温度121℃で30分間蒸気処理し、24時間室温に放置した後、瓶内壁を観察する。このとき水滴を認めないものを合格とする。

【0030】注射針刺し抵抗力試験(Determination of penetrability)；注射針7(21. S. W. G. 外径0.81mm、長さ38mm)が20cm/分の速度でゴム栓を貫通する時の力を測定機(テンション形ゴム引張試験機)で測定し、0.5kgで合格とする。本試験はBSの相当する試験の改良である。BS規格値は1000g以下で合格。

【0031】水蒸気透過性試験図1のガラス瓶中に2重量%食塩水溶液8mlを入れ、ゴム栓1を打栓し、さらにアルミキャップ4を巻き締める。このガラスびんをシリカゲルを入れたデシケーター中で室温にて6ヶ月間保存後、重量の変化を測定して、ゴム栓の水蒸気透過量(g)を測定する。5本の平均値を取り、1g以下を合格とする。本発明者らの自主規格試験である。

【0032】ヘッドスペース中のガス成分試験

図1のガラス瓶2中に2重量%食塩水溶液8mlを入れ、

ゴム栓1を打栓し、更にアルミキャップ4を巻き締める。このガラス瓶を耐圧容器にて温度121±1℃にて60分間蒸気加熱した後、約10時間放置する。次にガス用シリンジにて瓶内のヘッドスペース6のガス5mlを採取し、これをガスクロマトグラフ法にて測定する。カラム：10%OV-101(180~200メッシュWHP)、キャリアーガスHe50ml/分、カラム温度100~200℃(4℃/分昇温)、のピークの有無、大小を見る。本試験は近年問題になっているゴム及び配合剤による極微量ガス発生を調べる試験である。

【0033】耐アルカリ溶液試験；耐アルカリ容器にゴム栓10個を入れ、ゴム栓重量の10倍量の炭酸ソーダ0.5重量%溶液を加えた後、該ゴム栓を打栓してアルミキャップを巻き締める。次に高圧容器にて温度121℃にて30分間蒸気加熱する。室温まで放置、冷却後ゴム栓を除き、試験液を石英セルにて波長430nmと650nmの可視部の透過率を測定する。95%以上を合格とする。本試験は、ゴムと薬液との関係を試験する基本的な試験で透過率の低いゴム製品は採用不適である。

【0034】吸水試験；架橋成形したゴム製品を温度105℃常圧で3時間乾燥する。次に乾燥剤入りのデシケーター中に約1時間放置後その重量(A)を精秤する。次に該ゴム栓の10倍量の精製水中に浸し、そのまま耐圧容器内で温度121±1℃、30分間蒸気加熱する。冷却後、ゴム栓のみをデシケーター中に30分間放置して表面の水を取り、その時の重量(B)を精秤し、 $\frac{(B-A)}{(A)} \times 100$ (%)を求め、2重量%以下を合格とする。

【0035】薬液の吸着試験；硝酸イソソルビト(虚血性心疾患用薬、融点72℃、日本製薬製)を生理食塩水で希釈して0.040重量%として、この液3mlを正確に10ml瓶2に入れ、ゴム栓を打栓し、アルミキャップを巻き締めて、倒立状態にて24時間放置した。これを高速液体クロマトグラフ(HPLC製)にかけ、硝酸イソソルビトの量を測定して、吸着した減量を得る。カラム：FINEPAK SILC18(商品名、日本分光製)、移動相メタノール：水=7：3、流速1ml/分、検出器UV IDEC100-IV(商品名、日本分光製、220nm)

【0036】

【表3】

		実施例 1	実施例 2	実施例 3	比較例 1	比較例 2	第12改正日本薬局方、DIN 規格合格値
第 改 正 日 本 薬 局 方 試 験	性状(%)	99.5	99.5	99.5	99.5	99	99.0
	泡立ち	2分未満	2分未満	2分未満	2分未満	3分	3分以下
	pH	0.7	0.8	0.7	0.9	1.1	±1.0 以下(ブランクとの差)
	Zn (ppm)	1未満	1未満	1未満	1未満	1未満	1 ppm 以下
	KMnO <sub>4</sub> 還元性(ml)	1.3	1.5	1.4	1.8	2.0	2.0 ml 以下
	蒸発残留物 (mg)	1.0	1.3	1.1	2.0	2.2	2.0 mg 以下
	紫外吸収スペクトル	0.10	0.12	0.11	0.13	0.15	0.2 以下 [波長 220~350nm]
	急性毒性試験	適合	適合	適合	適合	適合	適合
	発熱性試験	適合	適合	適合	適合	適合	適合
	溶血性試験	適合	適合	適合	適合	適合	適合

加硫条件(温度170℃×10分)

【0037】

【表4】

		実施例 1	実施例 2	実施例 3	比較例 1	比較例 2	第12改正日本薬局方、DIN 規格合格値
特 殊 な 衛 生 試 験	微粒子量(5 $\mu$ m以上の個数)	3	5	2	7	13	3 個未満 (DIN規格NO )
	ゴム破片の剥離(個数)	0	0	0	1	5	
	薬液漏れ(ml)	0	0	0	0	0	
	撥水性	なし	なし	なし	なし	なし	
	注射針刺し抵抗力試験 (kg)	0.2	0.4	0.3	0.1	0.3	
	水蒸気透過性試験	0.5	0.6	0.5	1.4	1.2	
	ヘッドスペース中のガス成分試験	小	小	小	小	小	
	耐アルカリ溶液試験	99	99	99	99	98	
	吸水試験	0.3	0.4	0.3	0.2	0.5	
	薬液の吸着試験	1.2	1.5	1.2	1.2	1.7	

加硫条件(温度170℃×10分)

【0038】表3、表4に示すごとく、本発明品は全て第12改正日本薬局方の規格値に適合している。それに加え、最新の医薬品に対応できる容器、器具としての特殊な自主試験項目にも適合できる優れたゴム栓であることがわかる。一方比較例1、2の製品は例えばpH、蒸発残留物、微粒子量などの数項目において問題となる結果を示している。

【0039】〔実施例4〕BIIR (EXXON CHEMICAL社製、ML<sub>1+8</sub> 125℃ 50、臭素含有量0.6重量%) 100重量部、活性亜鉛華(堺化学工業株)製) 1.0重量部、N, N' -m-フェニレンビ

スマレイミド(川口化学工業(株)製) 2.0重量部、不溶性硫黄(日本乾溜(株)製) 0.2重量部をインターナルミキサーで混合した後に、温度160℃で7分間混練を行い、動的加硫物とした。別に精製したポリスルホン樹脂(商品名 UDEL POLYSULFONE、ユニオンカーバイド社製の繰り返し単位が前記u: [-Ph-SO<sub>2</sub>-Ph-O-Ph-C(CH<sub>3</sub>)(C H<sub>3</sub>)-Ph-O-] <sub>n</sub> を、N-メチルピロリドン:水=1:0.5を加熱してなる溶媒で2回洗浄したもの) 100重量部、エチレンビスステアリン酸アミド(日本化成(株)製) 1重量部、スチレン-ブタジエン-エチ

レン共重合体を無水マレイン酸5重量部 ブロック共重合体(試作品)5重量部をインターナルミキサー及び二連式押出機にて温度160~220℃でアロイ化物とした。次にTタイを通して均一なるフィルム板とした。厚さ0.4mm。JIS K6301に準拠して物理的性質を測定した結果、引張り強さ213kg/cm<sup>2</sup>、伸び210%であり、酸素ガス透過量を測定(柳本製作所製GTR製)したところ、温度20℃、乾燥状態では100cc/m<sup>2</sup>・24hrs/atmであった。混練前のBIIIRの加硫したフィルム板の酸素ガス透過量は300cc/m<sup>2</sup>・24hrs/atmであったことから、本発明によればIIR弾性体とポリスルホン樹脂を混合することにより酸素に対するガスバリアー性が改良されたことがわかる。なお、本発明のBIIIRとポリスルホン酸樹脂とのアロイ化物について第12改正日本薬局方の49.輸液用プラスチック容器試験法に準拠した試験を行い、その結果を後記の表5に示す。

【0040】〔実施例5〕CIIR(JSR CHLOROBUTYL 1068、商品名、日本合成ゴム(株)製、ML<sub>1+8</sub>125℃ 50、ハロゲン含量1.2重量%)100重量部、活性亜鉛華(堺化学工業(株)製)1.0重量部、ジエチルジチオカルバミン酸亜鉛1.0重量部をインターナルミキサーで混合した後、温度160℃で7分間混練を行い、動的加硫物とし

た。別に精製したポリスルホン酸〔商品名VICTREX PES、ICI社製、繰返し単位が前記f: (—Ph—SO<sub>2</sub>—Ph—O—)<sub>n</sub>のものを、テトラヒドロフラン:水:酢酸=20:5:0.1の加熱した溶媒にて洗浄後にアセトンでさらに洗浄したもの〕400重量部、スチレン-エチレン-スチレンブロック共重合体(シイルケミカル社扱い品)10重量部、ポリエチレンテレフタレート(クラレ(株)製ポリエチレンテレフタレート、グレードKS700)30重量部をインターナルミキサー及び二連式押出機にて温度160~220℃でアロイ化物とした。次にTタイを通して厚さ0.4mmの均一なるフィルム板とした。該フィルムについてJIS K6301に準拠して物理的性質を測定した結果、引張り強さ256kg/cm<sup>2</sup>、伸び180%であり、酸素ガス透過量を実施例4と同様に測定したところ、85cc/m<sup>2</sup>・24hrs/atmであった。作成した輸液剤容器を図2に示す。図2において8は注射液、9は容器口部、10は溶着栓、11は熱溶着部、12は懸垂けを表す。なお、第12改正日本薬局方の49.輸液用プラスチック容器試験法に準拠した試験を行い、その結果を後記の表5にあわせて示す。表5に示す如く、本発明による製品は第12改正日本薬局方の規格値に合格している。

【0041】

【表5】

項 目	実施例4	実施例5	薬局方規格合格値
性状(%) [波長220-350nm]	99.5	99.5	無色透明
泡立ち	1 未満	1 未満	3 分以内
pH	0.8	0.7	±1.5 以内
塩化物(ppm)	1	3	—
硫酸塩(ppm)	0.1	0.2	—
リン酸塩(ppm)	0.1	0.1	—
アンモニウム塩(ppm)	0.2	0.2	—
KMnO <sub>4</sub> 還元性(ml)	0.8	0.6	1.0 以下
蒸発残留物(mg)	0.3	0.4	1.0 以下
紫外吸収スペクトル	0.03	0.04	0.05 以下
急性毒性試験	適合	適合	適合
発熱性物質試験	適合	適合	適合
溶血性試験	適合	適合	適合

【0042】〔ポリスルホン酸の重合:2〕3000mlの三口フラスコにビス(3,5-ジメチル-4-ヒドロキシフェニル)スルホン 306g(1モル)、クロルベンゼン1000ml、スルホラン450mlを添加し、攪拌し、窒素ガス雰囲気下に60℃に加熱し、NaOH(45重量%)溶液250.5gを徐々に加え、50mlの精製水を加えて共沸によってクロルベンゼンを除き、温度120~140℃まで加熱を続け、反応物が145℃に達したならば130℃に冷却し、ビス(4-

フルオロフェニル)ケトン 218gを加え、200℃にて8時間反応する。重合反応物は冷却し、多量のメタノールを攪拌下に注ぎ、樹脂を析出させ、濾過し、アセトン、温水で洗浄して真空乾燥した。樹脂量450g  
繰返し単位 w: (—(CH<sub>3</sub>) (CH<sub>3</sub>) Ph—SO<sub>2</sub>—Ph (CH<sub>3</sub>) (CH<sub>3</sub>) —O—Ph—CO—Ph—O—)<sub>n</sub>、ガラス転移温度240℃。この樹脂を樹脂wと略す。

【0043】〔ポリスルホン酸の重合:3〕4000ml

1の三口フラスコに4, 4'-ジフェノール149g、4, 4'-ジクロロジフェニルスルホン234g、無水炭酸カリウム121.6g、N, N'-ジメチルアセトアミド1200gを仕込み、反応器内を窒素ガス雰囲気にし沸騰させて、N, N'-ジメチルアセトアミドと水を流出させる。約4時間重合反応を行った後、冷却し、炭酸カリウムを濾別し、多量のメタノールを攪拌下に注ぎ、樹脂体を析出させ、メタノール、温水で洗浄して真空乾燥を行なう。得られた樹脂量は340g。ガラス転移温度220℃。該樹脂は繰り返し単位が前記n:  $(-Ph-SO_2-Ph-O-Ph-Ph-O-)_n$  であり、該樹脂を樹脂nと略す。

り、該樹脂を樹脂nと略す。

【0044】〔実施例6～10〕各種のポリスルホン樹脂及びIIR弾性体について、表6に示す比率（重量部）に配合した。予め各原料粉末にて混合した後、押出機温度180～220℃にて動的加硫後に図3に示す注射筒形状に成形した。図3において13は注射筒、14は滑栓、15は注射針、16は押子棒を表す。得られた注射筒について厚生省告示第442号に準拠して試験を行った。結果を表7に示す。

【0045】

【表6】

		実施例 6	実施例 7	実施例 8	実施例 9	実施例 10
本発明のポリスルホン樹脂組成物配合（重量部）	ポリスルホン樹脂	n 100 —	w 100 —	u 80 f 20	f 80 n 20	f 100 —
	IIR弾性体ゴム	BIIR 10	CIIR 5	DVIIR 20	DVIIR 15	DVIIR 15
	活性亜鉛華 <sup>(a)</sup>	0.5	0.5	—	—	—
	アデオスタブPEP <sup>(b)</sup>	0.2	0.2	0.3	—	0.1
	ポリエチレンワックス	1	5	—	4	2
	ジエチルジチオカルバミン酸亜鉛	0.1	0.1	—	0.1	0.1
	1,1-ジ(t-ブチルペルオキシ)-3,3,5-トリメチルシクロヘキサン	—	—	0.15	0.1	0.1
	γ-グリシドキシプロピルトリメトキシシラン	2	2	—	1.5	—
混練温度(℃)	四フッ化エチレン樹脂	—	—	10	—	—
	エチレンビスステアリン酸アミド	—	—	0.3	—	—
混練温度(℃)		220～250	210～240	220～240	200～240	220～250

(a): 堺化学工業(株)製

(b): 旭電化(株)製

【0046】

【表7】

		実施例 6	実施例 7	実施例 8	実施例 9	実施例 10	厚生省告示規格値
厚生省告示項目	外観*	99.3	99.3	99.5	99.5	99.3	無色透明
	pH	0.2	0.3	0.1	0.1	0.1	+ 2.0 以下
	重金属(ppm)	0.1	0.1	0.02	0.03	0.03	1 ppm 以下
	KMnO <sub>4</sub> 還元性物質	0.2	0.3	0.1	0.1	0.2	2.0 ml 以下
	蒸発残留物	0.3	0.2	0.1	0.1	0.1	1.0 ml 以下

【0047】以上の本発明実施例では、ポリスルホン系樹脂として繰り返し単位がr、n、w、u、fの樹脂のいずれか1種と、IIR弾性体がIIR、BIIR、CIIR、DVIIRのいずれか各1種である組合せの

例を示したが、本発明においてはポリスルホン系樹脂の1種以上全種のいずれか、およびIIRの1種以上全種のいずれかの組合せも同様有効である。具体的には前記した繰り返し単位がa～wのうちの1種ないし全種の

ポリスルホン酸のうちのいずれかと、IIR、BIIR、CIIR、DVIIRのうちの1種ないし全種のうちのいずれかとの組み合わせからなる。

【0048】以下に本発明の実施態様を要約した形で示す。

(1) イソプチレン-イソブレン共重合系弾性体の1種以上95～5重量%とポリスルホン系樹脂の1種以上5～95重量%とを含有してなるポリスルホン系樹脂組成物。

(2) イソプチレン-イソブレン共重合系弾性体の1種以上100重量部に対しポリスルホン系樹脂を5～40重量部配合してなるポリスルホン系樹脂組成物からなる医療用、医薬品用器具栓体。

(3) イソプチレン-イソブレン共重合系弾性体の1種以上100重量部に対しポリスルホン系樹脂を5～30重量部配合してなるポリスルホン系樹脂組成物からなる医療用、医薬品用器具栓体。

(4) ポリスルホン系樹脂の1種以上100重量部に対してイソプチレン-イソブレン共重合系弾性体の1種以上を2～100重量部配合してなるポリスルホン系樹脂組成物からなる医療用、医薬品用器具。

(5) ポリスルホン系樹脂の1種以上100重量部に対してイソプチレン-イソブレン共重合系弾性体の1種以上を5～50重量部配合してなるポリスルホン系樹脂組成物からなる医療用、医薬品用器具。

(6) IIRと繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{S}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

(7) BIIRと繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-\text{Ph}-\text{C}(\text{CH}_3)(\text{CH}_3)-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

(8) CIIRと繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

(9) BIIRと繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-\text{Ph}-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

(10) CIIRと繰り返し単位が $(-\text{CH}_3)$

$(\text{CH}_3)\text{Ph}-\text{SO}_2-\text{Ph}(\text{CH}_3)(\text{CH}_3)-\text{O}-\text{Ph}-\text{CO}-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

(11) DVIIR、繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-\text{Ph}-\text{C}(\text{CH}_3)(\text{CH}_3)-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂及び繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

(12) DVIIR、繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は1～2000の整数を意味する〕で表されるポリスルホン樹脂及び繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-\text{Ph}-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は2～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

(13) DVIIRと繰り返し単位が $(-\text{Ph}-\text{SO}_2-\text{Ph}-\text{O}-)_n$ 〔但し $n$ は2～2000の整数を意味する〕で表されるポリスルホン樹脂とが配合されてなる上記(1)記載のポリスルホン系樹脂組成物。

【発明の効果】本発明による医療用、医薬品用器具は、下記の効果を奏する。

- 1) 日本薬局方の規格値に合格する高い衛生性を有する、
- 2) 酸素透過バリア性を有する、
- 3) 微粒子、ゴム破片の剥離、薬液漏れ、撥水性、注射針刺し抵抗、水蒸気透過量、ヘッドスペースのガス、耐アルカリ溶液性、吸水量、薬液の吸着に関して優れた衛生性を有する。

【図面の簡単な説明】

【図1】本発明に係る薬液用ゴム栓をガラス瓶に適用した一具体例を示す概略断面図である。

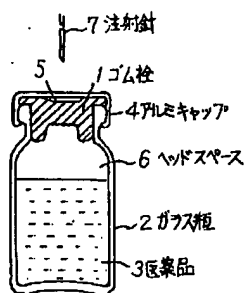
【図2】本発明に係る輸液用容器の断面図である。

【図3】本発明に係る注射器の断面図である。

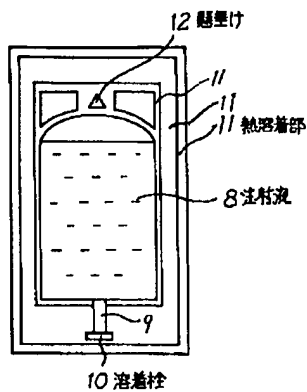
【符号の説明】

- |            |          |            |
|------------|----------|------------|
| 1 ゴム栓、     | 2 ガラス瓶、  | 3 医薬品、     |
| 4 アルミキャップ、 | 5 針入部、   | 6 ヘッドスペース、 |
| 7 注射針、     | 8 注射液、   | 9 容器口部、    |
| 10 溶着栓、    | 11 熱溶着部、 | 12 懸垂け、    |
| 13 注射筒、    | 14 滑栓、   | 15 注射針、    |
| 16 押子棒。    |          |            |

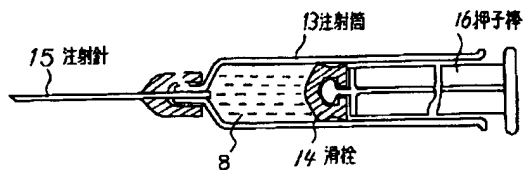
【図1】



【図2】



【図3】



フロントページの続き

(51) Int. Cl.<sup>6</sup>

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L B M

L R F

庁内整理番号

F I

技術表示箇所

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## CLAIMS

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[Claim(s)]

[Claim 1] The polysulfone system resin constituent which comes to contain an isobutylene-isoprene copolymerization system elastic body and polysulfone system resin.

[Claim 2] The polysulfone system resin constituent according to claim 1 which comes to contain 99 - 1% of the weight more than per sort of an isobutylene-isoprene copolymerization system elastic body, and 1 - 99% of the weight more than per sort of polysulfone system resin.

[Claim 3] The polysulfone system resin constituent according to claim 1 or 2 characterized by being the mixture or the alloy ghost of one or more sorts of an isobutylene-isoprene copolymerization system elastic body, and polysulfone system resin which comes to contain one or more sorts.

[Claim 4] Polysulfone system resin is  $n$  (-Ph-SO<sub>2</sub>-Ph-S-). It is the polysulfone system resin constituent according to claim 1 to 3 characterized by being what makes it a unit repeatedly [however, for  $n$  to mean the integer of 2-1000].

[Claim 5] Polysulfone system resin is  $n$  (-Ph-SO<sub>2</sub>-Ph-O-). It is the polysulfone system resin constituent according to claim 1 to 4 characterized by being what makes it a unit repeatedly [however, for  $n$  to mean the integer of 2-1000].

[Claim 6] The polysulfone system resin constituent according to claim 1 to 5 characterized by an isobutylene-isoprene copolymerization system elastic body containing isobutylene-isoprene copolymerization rubber, chlorination isobutylene-isoprene copolymerization rubber, bromination isobutylene-isoprene copolymerization rubber, or isobutylene-isoprene-divinylbenzene copolymerization rubber.

[Claim 7] the medical application which consists of a polysulfone system resin constituent which comes to contain an isobutylene-isoprene copolymerization system elastic body according to claim 1 to 6 and polysulfone system resin, and drugs -- an appliance -- an implement.

[Claim 8] medical application and drugs -- an appliance -- the medical application according to claim 7 characterized by an implement being a plug, and drugs -- an appliance -- an implement.

[Claim 9] medical application and drugs -- an appliance -- the medical application according to claim 7 characterized by an implement being a syringe, an infusion set, or a container, and drugs -- an appliance -- an implement.

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## DETAILED DESCRIPTION

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[Detailed Description of the Invention]

[0001]

[Industrial Application] the medical application which health nature of this invention is high, for example, uses as instrument ingredients, such as a container, and consists of the suitable new polysulfone system resin constituent for a mothball and this constituent of those contents, and drugs -- an appliance -- it is related with an implement.

[0002]

[Description of the Prior Art] About medical application and the instrument for drugs, the class, the engine performance, quality, the trial item, the examining method, the value of standard, etc.

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are set to the Pharmaceutical Affairs Law, a Japanese pharmacopoeia, and Notice of the Ministry of Health and Welfare. The product with which the iatrotechnique applied the various values of standard as a want matter to each item, an aforementioned approach, and an aforementioned numeric value further in the ever-advancing time is manufactured like today.

[0003] The transparent raw material used for medical application and drugs is mainly a glass product, and came as an instrument combining the Plastic solid which uses natural rubber as a raw material as an elasticity elastic body for being able to come, and it being alike, for example, sealing. however, recent years -- synthetic resin and synthetic rubber -- medical application and drugs -- an appliance -- it inquires as a raw material of an implement and marketing is also carried out.

[0004]

[Problem(s) to be Solved by the Invention] by the way, the medical application and drugs which are conventionally used widely -- an appliance -- there are the following properties and troubles about an implement raw material. Plasticizers, such as stabilizers, such as for example, a tin system added by resin, cadmium, and a zinc salt double salt compound, and dioctyl phthalate, dioctyl adipate, tricresyl phosphate, etc. should elute and pollute a polyvinyl chloride (abbreviated name PVC) in drugs and a drug solution. Environmental destruction may be caused when the resin product other than the PVC raw material monomer remaining in resin is discarded. The product with polyethylene (abbreviated name PE) made [ with a product ] from it because softening temperature is low serves as an instrument which cannot carry out high-pressure steam sterilization. Pasteurization is difficult although high-pressure steam sterilization can do polypropylene (abbreviated name PP). There is a report which denaturalized, made resin transparency and used it as medical-application raw material (JP,3-163144,A, said 3-28246 each number official report). Although PE and PP are comparatively excellent in the permeability-proof over moisture and humidity, gas cutoff nature, such as oxygen and carbon dioxide gas, is bad, and a content drug has the problem oxidized and discolored. As an approach of improving the fault of such PE and PP [ whether ethylene and the saponification object (abbreviated name EVOH) of a vinyl acetate copolymerization component are mixed with PE and PP, and ] or making it the package object which carried out the laminating to PE, PP, and EVOH is proposed (for example, "package film --) practical use thermal-resistance:plastics age of a shaping container and a bottle No. 6 (1992) "high barrier multilayer plastic envelope: Pharmaceutical factory vol.6, No.12 (1986)", "The gas barrier nature container of plastics, the gas barrier nature of plastics, and container shaping approach:hood packaging vol.32-No.3", "high gas barrier nature wrapping : Plastics vol.38, No.5" (1987), The application and the actual condition to "barrier nature resin container : Plastics vol.27, No.5" (1977), "barrier nature composite material and PVDC : KOMPA tech vol.15, No.1" (1987), Barrier resin which functionalizes "packing material : KOMPA tech vol.17, No.6(1989)", The "latest functional wrapping : Industrial ingredient vol.37, No.14(1989)", The trend of the "latest functional container: Since water absorption and hygroscopicity of EVOH are very strong, when humidity and moisture live [ science, industrial vol.61-4 (1987)", etc. ] together at the time of high-pressure steam sterilization etc., it has the fault that gas electric shielding validity, such as oxygen and air, is very weak. Although a glass raw material is a raw material excellent in a heatproof, an acid-proof history, transparency, etc., there is a trouble that the alkali generated from a glass front face and the particle which exfoliates from glass pollute a chemical and a drug solution. There are problems, such as an offensive odor and formaldehyde generating, from the resin of polyphenylene ether resin (abbreviated name PFE), polyethylene terephthalate (abbreviated name PET), polybutylene



terephthalate (abbreviated name PBT), and a polycarbonate (abbreviated name PC). In case natural rubber (abbreviated name NR) and the polyisoprene rubber (abbreviated name IR) of synthetic rubber, butadiene rubber (abbreviated name BR), styrene butadiene rubber (abbreviated name SBR), nitrile rubber (abbreviated name NBR), isobutylene isoprene rubber (abbreviated name IIR), halogenation isobutylene isoprene rubber (BIIR, CIIR), etc. are used for medical application and drugs, they have the trouble that the vulcanizing agent, vulcanization accelerator, and reinforcing agent which vulcanize rubber cause elution, exfoliation, etc., and pollute a chemical and a drug solution. this invention persons have proposed the rubber goods (JP,5-43740,B) which already blended the polyethylene of ultrahigh molecular weight with IR, BR, and SBR, and the rubber goods (JP,4-213347,A) which combined the special vulcanizing agent with IIR. the medical application and drugs using the new raw material with which this invention canceled the fault of elegance conventionally -- an appliance -- the medical application which consists of the new polysulfone system resin constituent and new it which especially health nature is high, it uses for instruments, such as a container, and there are no pollutant elution, exfoliation, etc. to contents for the purpose of offer of an implement, and were suitable for the mothball of contents, and drugs -- an appliance -- it has the intention of an implement.

[0005]

[Means for Solving the Problem] This invention offers the polysulfone system resin constituent which comes to contain an isobutylene-isoprene copolymerization system elastic body and polysulfone system resin as The means for solving a technical problem. As a desirable mode in this invention, the polysulfone system resin constituent which is the mixture or the alloy ghost of one or more sorts of an isobutylene-isoprene copolymerization system elastic body and polysulfone system resin which comes to contain one or more sorts is mentioned especially. moreover -- as the especially desirable mode in this invention -- this polysulfone system resin --  $n$  (-Ph-SO<sub>2</sub>-Ph-S-) The thing which makes it a unit repeatedly [however, for  $n$  to mean the integer of 2-1000], or (-Ph-SO<sub>2</sub>-Ph-0-)  $n$  what makes it a unit repeatedly [however, for  $n$  to mean the integer of 2-1000] -- it comes out and a certain thing is mentioned. the medical application which consists of a polysulfone system resin constituent with which this invention comes to contain the isobutylene-isoprene copolymerization system elastic body and polysulfone system resin of this invention further described above, and drugs -- an appliance -- an implement is offered. A plug is especially mentioned as a desirable mode of the medical application of this invention, and the instrument for drugs. furthermore, the medical application of this invention and drugs -- an appliance -- it is also an especially desirable mode that an implement is a syringe, an infusion set, or a container.

[0006]

[Function] The isobutylene-isoprene copolymerization system elastic body (it may abbreviate to an IIR elastic body hereafter) concerning this invention Isobutylene-isoprene copolymerization rubber (IIR), the rubber which made chlorine react to isobutylene-isoprene copolymerization rubber (CIIR), The rubber which made the bromine react to isobutylene-isoprene copolymerization rubber (BIIR), It is the generic name of isobutylene-isoprene-divinylbenzene copolymerization rubber (abbreviated name DVIIR). It is the elastic body which comes to vulcanize IIR, CIIR, BIIR, and DVIIR using one or more sorts chosen from a vulcanizing agent, for example, sulfur, a zinc white, magnesium, an amine compound, organic peroxide, a MAIMIDO compound, etc.

[0007] the IIR elastic body concerning this invention -- 4.5 or less % of the weight of isoprene radical contents, and average molecular weight 10,000-650,000 For example, the 100 weight

sections of IIR are received. it is -- Sulfur, for example, t-butylperoxy isopropyl, n-butyl -4, 4'-screw (t-butyl peroxide) valerate, Organic peroxide, such as 1 and 1-JI (t-butylperoxy) 3 and 3 and a 5-trimethyl cyclohexane, For example, maleimide, such as N and N'-m-phenylene bismaleimide A vulcanizing agent and dipentamethylenethiuramtetrasulfide, such as a zinc white, It can manufacture with the well-known means of vulcanizing vulcanization accelerators, such as zinc diethyldithiocarbamate, tetramethylthiurammonosulfide, and tetramethylthiuramdisulfide, 0.5 - 2 weight section, in addition by carrying out heating application of pressure, for example.

[0008] The elastic body of BIIR and CIIR concerning this invention can be manufactured by carrying out 1-5 weight section addition, and heating and pressurizing vulcanizing agents, such as a zinc white and magnesium oxide, for example, the organic amine compound which has an amino group and a carboxyl group in intramolecular, the same vulcanization accelerator as the case of said IIR elastic body, etc. to the 100 weight sections of BIIR and CIIR.

[0009] The elastic body of DVIIR concerning this invention can be manufactured by carrying out 0.5-2 weight section combination, heating and pressurizing the same organic peroxide as the elastic body of IIR, and a case, and vulcanizing it to the DVIIR100 weight section.

[0010] As preparation of vulcanization of the elastic body concerning this invention, and the resin constituent of this invention, and the concrete technique of shaping from this constituent After mixing the various above compounding agents beforehand to crude rubber, it pressurizes at 160-220 degrees C with an internal mixer or a mixed extruding machine. After performing dynamic vulcanization to heat, it can mix to polysulfone resin or mixing, the approach of alloy-izing, or the approach of blending the vulcanization accelerator other than a vulcanizing agent, blending a polysulfone acid further, and carrying out shaping vulcanization within metal mold can be adopted.

[0011] The polysulfone system resin concerning this invention is resin of the super-macromolecule object which used association with an aromatic series system hydrocarbon group and a sulfonyl group (-SO<sub>2</sub>-) as the principal component. A phenyl group and a phenylene group are mentioned as this aromatic hydrocarbon radical. The phenyl group or phenylene group combined with one sulfonyl group has one case and 2-7 things, and when it is the latter, they is a biphenyl radical, a bis-phenyl alkane radical, a triphenyl radical, etc. Moreover, the polysulfone system resin of this invention can have low-grade alkyl groups other than a phenyl group, a phenylene group, or a sulfonyl group, such as an oxy-radical (-O-), a thio radical (-S-), a carbonyl group (-CO-), and a methyl group, as a constituent.

[0012] The example of the repeat unit of the polysulfone system resin concerning this invention is given to below. In the following example a-w, a code means as follows. Ph: -- phenyl group or phenylene group, and -SO<sub>2</sub>-: -- a sulfonyl group, a -O-:oxy-radical, a -S-:thio radical, a -CO-:carbonyl group, and a CH<sub>3</sub>-:methyl group. n: Integer a of 2-1000 : () [ -Ph-SO<sub>2</sub> ] -) -- nb:(-Ph-SO<sub>2</sub>-Ph-) nc:(-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph) nd:(-Ph-SO<sub>2</sub>-Ph-Ph-Ph-SO<sub>2</sub>-Ph) ne: () [ -Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub> ] -) -- nf:(-Ph-SO<sub>2</sub>-Ph-O-) ng:(-Ph-SO<sub>2</sub>-Ph-SO<sub>2</sub>-Ph-O-) nh:(-Ph-SO<sub>2</sub>-Ph-SO<sub>2</sub>-Ph-O-Ph-O-) ni: () [ -Ph-SO<sub>2</sub>-Ph-PhSO<sub>2</sub> ] - Ph-O-nj:(-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph-O-Ph-O-) nk:(-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-) nl:(-Ph-SO<sub>2</sub>-Ph-Ph-O-Ph-O-) nm : () [ -Ph-SO<sub>2</sub> ] - Ph-O-Ph-O-Ph-O- nn:(-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-) no:(-Ph-SO<sub>2</sub>-Ph-CH<sub>2</sub>-Ph-SO<sub>2</sub>-Ph-O-) np:[-Ph-SO<sub>2</sub>-Ph-Ph-O-Ph-C () [ CH<sub>3</sub> ] -Ph-O-]nq:[-Ph-SO<sub>2</sub> (CH<sub>3</sub>) - Ph-O-Ph-C(Ph) (Ph)-Ph-O-]nr:(-Ph-SO<sub>2</sub>-Ph-S-) ns:(-Ph-SO<sub>2</sub>-Ph-O-Ph-CO-Ph-O-) nt:(-Ph-SO<sub>2</sub>-Ph-O-Ph-O-) nu:[-Ph-SO<sub>2</sub> - Ph-O-Ph-C (CH<sub>3</sub>) () [ CH<sub>3</sub> ] -Ph-O-:] [nv:(-Ph-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph-O-) nw] [-(CH<sub>3</sub>) (CH<sub>3</sub>)-Ph-SO<sub>2</sub>-Ph(CH<sub>3</sub>) (CH<sub>3</sub>)-O-Ph-CO-Ph-O-] n [0013] The polysulfone system resin concerning this invention is a

polymer which uses as a principal component a repeat unit which was described above. A conventionally well-known technique, for example, JP,45-21318,B -- said -- 46-21458 -- said -- 47-617 -- said -- 53-25879 -- said -- 56-2091 -- said -- 61-12930 and JP,52-96700,A -- said -- 53-10696 -- said -- 59-12930 -- said -- 63-21030 -- said -- 63-243128 -- JP,1-315422,A -- said -- 1-318040 -- said -- 3-41120 -- said -- 3-95200 -- said -- a polymerization is carried out with the technique indicated by 4-335030, said 5-9453 each number official report, etc., and it can manufacture. average molecular weight of this polysulfone system resin 5,000-950,000 it is -- many carrying-out [ using an alkaline catalyst ]-in polar organic solvent-polymerization of this resin approaches are adopted. However, as for the polysulfone system resin used for this invention, what repeated solvent washing, warm water washing, etc. and removed a raw material compound, the oligomer of low molecular weight, an inorganic compound (many are NaCl), etc. as much as possible is desirable. Various kinds of well-known techniques are applicable to the purification means of such this polysulfone system resin. It is tough nature, high intensity, thermal resistance, KUREBU-proof nature, and abrasion resistance, and the polysulfone acid system resin concerning this invention is resin of a frank color and transparency, it has the resistance excellent also in an acid, alkali, and salting in liquid, and can also bear the high temperature service in the inside of a detergent and a hydrocarbon. furthermore -- since it has the property that it can be repeatedly equal also to 130 degrees C and the autoclave sterilization for 30 minutes with steam-proof and hot water resistance -- medical application and drugs -- an appliance -- it uses for an implement and is dramatically advantageous.

[0014] In addition, what added the stabilizer of the amount of macromolecules comparatively as polysulfone acid resin of this invention is desirable. As such a stabilizer, for example Tetrakis [methylene (3, 5-G t-butyl-4-hydroxyphenyl) propionate] methane:trade name IRUGA NOx 1010 (Ciba-Geigy make), Triethylene glycol-bis--3-(2-t-butyl-4-hydroxy-5-methylphenyl) propionate : Trade name IRUGA NOx 245 (Ciba-Geigy make), Screw (2, 6-G t-butyl-4-methylphenyl) PENTA ERIS toll diphosphite : Trade name ADEO stub PEP-36 (product made from Asahi Electrification), It is desirable for N and N'-m-phenylene bismaleimide, a tocopherol, etc. to be mentioned and to carry out 0.01-0.5 weight section addition of these one or more kinds to this polysulfone acid resin 100 weight section.

[0015] The constituent of this invention comes to contain the above-mentioned IIR elastic body and polysulfone system resin. Moreover, this IIR elastic body and polysulfone system resin can also blend one or more sorts respectively. Polysulfone acid system resin is preferably blended in 95 - 5% of the weight of the range 99 to 1% of the weight to an IIR elastic body. this blending ratio of coal -- medical application and drugs -- an appliance -- it is desirable to choose corresponding to the class of implement and the hard and soft degree suitable for that instrument. For example, when applying as an instrument plug for medical application and drugs, it is desirable to carry out 5-40 weight section combination of the polysulfone acid system resin to the IIR elastic body 100 weight section. It is 5 - 30 weight section especially preferably. This is because the physical characteristic as a plug, for example, the physical characteristic needed in the case of injection needling, will be lacked under in 5 weight sections when it cannot acquire to the desired end, suitable property, for example, elasticity, but 40 weight sections are exceeded. moreover, medical application and drugs -- an appliance -- the elastic body chosen from BIIR, CIIR, and DVIIR to the polysulfone acid 100 weight section when using it for the body of a container of an implement etc. -- the 2 - 100 weight section -- desirable -- 5 - 50 weight section -- mixing -- or it alloy-izes. the resin object of thermal resistance and high elasticity -- becoming -- a medical-application instrument and drugs -- an appliance -- as an implement, thermal resistance

is high, therefore serves as the container and instrument which repeat heat sterilization, high voltage auto KUREBU sterilization, and ethyleneoxide sterilization, and can perform them. Therefore, it fabricates and is suitable for the instrument for an operation, a syringe, a syringe-cum-a container, etc. Moreover, it could be made the film, and could use for raw materials, such as bags for infusion solutions, and it became clear that it could use suitable for the preservation container of the high TARORI transfusions containing grape sugar and amino acid etc. In this film shaping, it is desirable to mix processing aid, a graft copolymer, etc. to the constituent of this invention.

[0016] The constituent which consists of the IIR elastic body and polysulfone resin of this invention as mentioned above may be mixture, and can also be made into an alloy ghost. Moreover, processing aid can be added in order to make the workability of mixture and an alloy ghost, and a moldability good. As such processing aid, for example Higher-fatty-acids:, for example, arachin acid, Metal soap:, for example, zinc stearate, calcium stearates, such as behenic acid, Fatty-acid amides:, for example, styrene bis-stearyl amides, such as an aluminum stearate salt, Ethylene bis-oleic amide, a behenic acid amide, octadecanamide, etc., Higher-fatty-acid ester:, for example, long-chain-fatty-acid ester of 20-24 carbon numbers, Wax:, for example, a micro crystallin wax, such as a sorbitan fatty acid ester The amount polyethylene of giant molecules, alcohols of 16-18 carbon numbers, such as polyethylene wax, One or more kinds, such as silicone oils, below 10 weight sections, a graft copolymer, a block copolymer (for example, the hydrogenation object of a styrene-butadiene-rubber-block copolymer and this copolymer --) A poly dimethylsiloxane-polyethylene oxide block copolymer, an ethylene-glycidyl methacrylate graft copolymer etc. -- etc. -- from -- by blending one or more kinds chosen below 20 weight sections, it can consider as a very uniform alloy ghost, and workability can be improved.

[0017] As a means to mix and knead the IIR elastic body and polysulfone system resin concerning this invention, and to alloy-ize them, conventionally, using well-known equipment, for example, an internal mixer, one shaft, or a twin screw extruder, it can carry out at the temperature of 120-380 degrees C, and becomes uniform mixture and an alloy ghost. moreover -- as it is -- extrusion molding -- carrying out -- medical application and drugs -- an appliance -- it can also consider as an implement. the medical application concerning this invention, and drugs - - an appliance -- the product fabricated as an implement -- each -- 48. test for rubber closure for aqueous infusions of a Japanese pharmacopoeia (the 12th amendment), the plastic envelope examining method for 49. infusion solutions, and Notice of the Ministry of Health and Welfare No. 301 -- said -- No. 413 -- said -- the medical application which suits No. 442, and drugs -- an appliance -- it is an implement and can consider as a syringe, a syringe-cum-a container, and an infusion set instrument. Moreover, it becomes drugs and the container which has the outstanding description that the quality can be held for a content chemical over a long period of time as a container of a drug solution.

[0018]

[Example] Hereafter, although an example explains this invention to a detail, this invention is not limited to these.

[Polymerization:1 which is the Pol sulfonic acid] NaHS(47 % of the weight of concentration) 358g, NaOH(48 % of the weight of concentration) 225g, CH<sub>3</sub> COONa123g, Na<sub>2</sub> CO<sub>3</sub> 19g, and N-methyl pyrrolidone 2376g are taught to a 10,000ml autoclave, and it agitates at the temperature of 130 degrees C for 3 hours, passing nitrogen gas. After cooling the mixture at 70 degrees C, it mixes agitating N-methyl pyrrolidones 297g and 4 and 4-dichloro diphenylsulfone

878.5g mixture in this reactant, it heats at the temperature of 260 degrees C for 4 hours, and a polymerization is performed. next -- while cooling agitating to 120 degrees C with 1-degree-C speed for /and agitating in 9g [ of acetic acids ], and N-methyl pyrrolidone 2583g -- gradual -- slushing -- a polymer -- a particle -- after making it deposit as powdered and carrying out a \*\* exception -- 1500ml of 70-degree C warm water -- washing -- it washes in methanol 1000ml further. It is IRUGA NOx 1010 to the obtained polymer 100 weight section. It dries in a vacuum after adding the 0.1 weight sections. It was the amount of resin of 632g and glass transition temperature of 192 degrees C which were obtained. The repeat unit of this resin was n (-Ph-SO<sub>2</sub>-Ph-S-) r, i.e., the above mentioned repeat unit, in light yellow transparence. This resin is abbreviated to Resin r.

[0019] The [examples 1-3 and the example 1 of a comparison, and 2] IIR[trade name The 2.0-mol % and ML1+8 100 \*\* 42]100 weight section is received whenever [ JSR Butyl 365, Japan Synthetic Rubber Co., Ltd. make, and partial saturation ]. the ratio (the section in a table means the weight section) which shows polysulfone resin r obtained above in the following table 1 -- blending -- an internal mixer and a twin screw extruder -- kneading -- 2 rolls -- \*\*\*\*(ing) -- combination -- the ground was created.

[0020]

[A table 1]

[0021] \*\* of the above-mentioned table 1 - \*\* are as follows.

\*\* PE : low density polyethylene, show REXX M222, the Showa Denko K.K. make, 92 degrees C of softening temperatures.

\*\* Bulking agent : trade name Whitetex:Southern Product made from Clay.

\*\* 2, the 5-dimethyl -2, 5-JI (t-butylperoxy) hexane.

\*\* N and N'-m-phenylene bismaleimide.

\*\* Micro crystallin wax (melting point of 110 degrees F, NIPPON SEIRO CO., LTD. make).

\*\* gamma-mercaptoptrimethoxysilane : Nippon Unicar make A-189 (trade name).

[0022] the combination obtained above -- the ground with an oscillating disk rheometer (O. it being called R.R. for short) testing machine Society of Rubber Industry, Japan -- VOL.40 (1967) -- p874 and ASTM D-2705 and SRIS 3102 A minute angle oscillation (torsional oscillation) of an oscillating-type vulcanization trial [revolution reciprocating motion is given. the -- corresponding -- stress -- torque value -- \*\*\*\*\* -- measuring -- torque -- a peak price -- (-- c --) -- asking -- this -- torque -- the minimum value -- (-- b --) -- a difference -- asking -- ] -- carrying out -- the result -- a table 2 -- collecting -- being shown .

[0023]

[A table 2]

[0024] Since an example 1 has the difference of torque value [(c)-(b)] larger than the ground of the example 1 of a comparison, and the example 2 of a comparison and hardness is also large as shown in a table 2, it turns out that rubber is a high elasticity object. Moreover, in the example 2 which increased the quantity of Resin A, and the example 3 which added the silane coupling agent, the addition effectiveness shows torque value higher than an example 1 and Hs value, respectively.

[0025] next, it obtained above -- each -- the rubber stopper for drugs shown in drawing 1 was fabricated by the vulcanization condition: temperature of 170 degrees C, and : during 10 minutes using the ground. In addition, a carboy 2 is capped with a rubber stopper 1, the condition that the aluminium cap 4 wound and fastened is shown, in 3, drawing 1 is the outline sectional view of one example which applied this rubber stopper to the carboy, and, as for drugs and 5, 7 shows [ needle admission into a club and 6 show a head space, and ] a hypodermic needle. The special health trial which the examining methods and this invention persons of the 12th amendment Japanese pharmacopoeia are using about each rubber stopper was performed. The result is shown in a table 3 and a table 4. A special health trial is performed as follows.

[0026] The other special amounts of health trial particles (trial of the particle weight generated from a rubber stopper); ten rubber stoppers are put in into a hard-glass bottle, it vibrates on a package with a film and 300ml of non-\*\*\*\* and container opening are vibrated for 20 seconds with 2 revolutions-per-second extent by hand. After putting after that for 1 hour, the number of an underwater particle is measured with an optical electric shielding mold automatic particle measuring instrument (product made from HIAC). In addition, since existence of the particle 5 micrometers or more in a parenteral solution causes the problem of blockading a blood vessel, it serves as a critical item.

[0027] Exfoliation of a rubber fragment (Fragmentation); 5ml of water is put into the bottle (10ml capacity) of the configuration shown in drawing 1 as 2, a rubber stopper 1 is capped, and then an aluminium cap 4 is rolled and fastened. 2ml water is put into the glass syringe which attached the trial needle [22G (0.70x32mm)], and the needle admission into a club 5 of a rubber stopper is made to penetrate this 20 times. A hypodermic needle is drawn out after pouring in the water in a glass syringe into a bottle at the time of the 20th penetration. After vibrating the inside

of a bottle, a rubber stopper is removed, content liquid is filtered and the rubber piece number on a filter paper is counted. Although an exam method is what improved the approach of the British standard 3263 (it abbreviates to BS) and the specification of BS is three or less rubber pieces, less than two pieces are demanded in this current this industry.

[0028] Drug solution leakage; 500ml of water is put into the bottle 2 of drawing 1 , a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened. Leave it for 1 hour, running through with the rocket needle 7 (the JMS nature No. 200, rocket needle with an infusion set) from the needle admission into a club 5 of the rubber stopper after heating this for 30 minutes at 121 degrees C within a container, and maintaining a bottle at a handstand condition, then stab with a vent wire, 400ml of water in a bottle is made to flow out, the liquid spill at drawing and this time (ml) is observed for the rocket needle from a rubber stopper at this event, and it measures.

[0029] Water repellence (Water repellency); 500ml of distilled water is put into the bottle 2 of drawing 1 , a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened. Next, a bottle wall is observed, after putting into a proof-pressure heating container, steaming for 30 minutes at the temperature of 121 degrees C and leaving it in a room temperature for 24 hours. What does not accept waterdrop at this time is considered as acceptance.

[0030] Injection needling resistance-force trial (Determination of penetrability); the force in case a hypodermic needle 7 (21. the S.W.G. outer diameter of 0.81mm, die length of 38mm) penetrates a rubber stopper the rate for 20cm/is measured with a measurement machine (tension form spreading tension testing machine), and it considers as acceptance by 0.5 kg. An exam is amelioration of the trial to which BS is equivalent. BS value of standard passes by 1000g or less.

[0031] 8ml of brine solutions is put in 2% of the weight into the carboy of the steam permeability test chart 1 , a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened further. Change of weight is measured after preservation for six months at a room temperature in the desiccator into which silica gel was put for this glass bottle, and the amount of steam transparency of a rubber stopper (g) is measured. The five averages are taken and 1g or less is considered as acceptance. It is this invention persons' independence specification testing.

[0032] 8ml of brine solutions is put in 2% of the weight into the carboy 2 of gas-constituents trial drawing 1 in a head space, a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened further. It is left for about 10 hours, after carrying out steamy heating of this carboy for 60 minutes at the temperature of 121\*\*1 degree C with a proof-pressure container. Next, gas 5ml of the head space 6 in a bottle is extracted in the syringe for gas, and this is measured in gas chromatography. Column: See the existence of the peak of a part for 101 (180-200 mesh WHP) and carrier gas helium50ml/, and 10%OV-temperature [ column / of 100-200 degrees C (4 degree-C temperature up / A part for //) ] \*\*, and size. An exam is a trial which investigates the ultralow volume generation of gas by the rubber and the compounding agent which have been a problem in recent years.

[0033] Alkali-proof solution trial; ten rubber stoppers are put into an alkali-proof container, and it is sodium carbonate 0.5 of the amount of 10 times of rubber stopper weight. After adding a weight % solution, this rubber stopper is capped, and an aluminium cap is rolled and fastened. Next, steamy heating is carried out for 30 minutes at the temperature of 121 degrees C with a high pressure vessel. Except for the rubber stopper after neglect and cooling, the wavelength of 430nm and the permeability of a 650nm visible region are measured for test fluid in a quartz cell to a room temperature. 95% or more is considered as acceptance. the fundamental trial whose exam examines the relation between rubber and a drug solution -- the rubber goods with low

permeability -- adoption -- it is unsuitable.

[0034] Water absorption test; the rubber goods which carried out bridge formation shaping are dried by temperature the ordinary pressure of 105 degrees C for 3 hours. Next, it is the weight (A) after about 1-hour neglect in the desiccator containing a desiccating agent. It weighs precisely. Next, it dips into the purified water of the amount of 10 times of this rubber stopper, and steamy heating is carried out for 30 minutes the temperature of 121\*\*1 degree C within a proof-pressure container as it is. After cooling, only a rubber stopper is left for 30 minutes in a desiccator, surface water is taken, and it is the weight at that time (B). It weighs precisely, and asks for  $((B-A)/A \times 100 \%)$ , and 2 or less % of the weight is considered as acceptance.

[0035] The adsorption test of a drug solution; nitric-acid iso SORUBITO (the medicine for ischemic heart disease, the melting point of 72 degrees C, product made from Japanese-made medicine) was diluted with the physiological saline, and as 0.040 % of the weight, 3ml of this liquid was put into the 10ml bottle 2 at accuracy, the rubber stopper was capped, the aluminium cap was rolled, and it was left in the state of the handstand in total for 24 hours. This is applied to a high-speed liquid chromatograph (product made from HPLC), the amount of nitric-acid iso SORUBITO is measured and the loss in quantity which adsorbed is obtained. Column: FINEPAK SILC18 (a trade name, Jasco make), a mobile-phase methanol: Water = 7:3 and 1ml [ of the rates of flow ] a part for /, detector UVIDEC100-IV (a trade name, the Jasco make, 220nm)

[0036]

[A table 3]

[0037]

[A table 4]



[0038] As shown in a table 3 and a table 4, all this invention articles conform to the value of standard of the 12th amendment Japanese pharmacopoeia. In addition to it, it turns out that they are the container which can respond to the newest drugs, and the outstanding rubber stopper which can also suit the special independence trial item as an instrument. On the other hand, the product of the examples 1 and 2 of a comparison shows the result which poses a problem in several items, such as pH, a residue on evaporation, and the amount of particles.

[0039] [Example 4] The BIIR(product [ made from EXXON CHEMICAL ], ML1+8 125 degree-C 50, 0.6 % of the weight of bromine contents) 100 weight section, 1.0 weight sections [ made from an active white (Sakai Chemical Industry stock) ], N, and N'-m-phenylene bismaleimide (Kawaguchi Chemical Industry Co., Ltd. make) 2.0 weight section, insoluble sulfur (after mixing the 0.2 weight section made from Japanese Dry distillation with an internal mixer, kneading was performed for 7 minutes at the temperature of 160 degrees C, and it considered as dynamic vulcanizate.) the polysulfone resin (it POLYSULFONE(s) trade name UDEL [ ] --) refined independently the Union Carbide repeat unit -- said u: [-Ph-SO<sub>2</sub>-Ph-O-Ph-C(CH<sub>3</sub>)(CH<sub>3</sub>)-Ph-O-] n N-methyl pyrrolidone : The thing] 100 weight section washed twice with the solvent which comes to heat water =1:0.5, The ethylene bis-octadecanamide (Nippon Kasei Chemical Co., Ltd. make) 1 weight section, It is the maleic-anhydride 5 weight section about a styrene-butadiene-ethylene copolymer. The block-copolymer (prototype) 5 weight section was made into the alloy ghost at the temperature of 160-220 degrees C with the internal mixer and the 2 ream type extruder. Next, it considered as the uniform film plate through T Thailand. 0.4mm in thickness JIS the place which are the tensile strength of 213kg/cm<sup>2</sup>, and 210% of elongation, and measured the amount of oxygen gas transparency as a result of measuring a physical property based on K6301 (product made from Yanamoto factory GTR) -- the temperature of 20 degrees C, and dryness -- 100cc/m ] 2 and 24 hrs/atm it was . the amount of oxygen gas transparency of the film plate which BIIR before kneading vulcanized -- 300 cc/m<sup>2</sup> and 24 hrs/atm it was -- according to this invention, by mixing polysulfone resin with an IIR elastic body shows from

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things that the gas barrier nature to oxygen was improved. In addition, the trial based on the plastic envelope examining method for 49. infusion solutions of the 12th amendment Japanese pharmacopoeia about the alloy ghost of BIIR of this invention and polysulfone acid resin is performed, and the result is shown in the after-mentioned table 5.

[0040] [Example 5] After mixing the CIIR(JSR CHLOROBUTYL 1068, trade name, Japan Synthetic Rubber Co., Ltd. make, ML1+8 125 degree-C 50, 1.2 % of the weight of halogen contents) 100 weight section, the active white (Sakai Chemical Industry Co., Ltd. make) 1.0 weight section, and the zinc-diethyldithiocarbamate 1.0 weight section with an internal mixer, kneading was performed for 7 minutes at the temperature of 160 degrees C, and it considered as dynamic vulcanizate. Polysulfone acid [trade name VICTREX PES, the product made from ICI which were refined independently, A repeat unit is said f: (-Ph-SO<sub>2</sub>-Ph-O-) n. A thing tetrahydrofuran: -- water: -- the thing] 400 weight section further washed with the acetone after washing with the solvent which acetic-acid = 20:5:0.1 heated -- The styrene-ethylene-styrene block-copolymer (Shilu chemical company treatment article) 10 weight section, The polyethylene terephthalate (polyethylene terephthalate [ by Kuraray Co., Ltd. ], grade KS700) 30 weight section was made into the alloy ghost at the temperature of 160-220 degrees C with the internal mixer and the 2 ream type extruder. Next, it considered as the uniform film plate with a thickness of 0.4mm through T Thailand. this film -- JIS physical based on K6301 -- the place which are the tensile strength of 256kg/cm<sup>2</sup>, and 180% of elongation, and measured the amount of oxygen gas transparency like the example 4 as a result of measuring a characteristic -- 85 cc/m<sup>2</sup> and 24 hrs/atm it was . The created transfusions container is shown in drawing 2 . In drawing 2 , in the container regio oralis and 10, a joining plug and 11 express a heat welding and 12 expresses [ 8 / a parenteral solution and 9 ] \*\*\*\*\*. In addition, the trial based on the plastic envelope examining method for 49. infusion solutions of the 12th amendment Japanese pharmacopoeia is performed, and the result is united and shown in the after-mentioned table 5. As shown in a table 5, the product by this invention has passed the value of standard of the 12th amendment Japanese pharmacopoeia.

[0041]

[A table 5]

[0042] [Polymerization:2 which is a polysulfone acid] It is a screw (3, 5-dimethyl-4-hydroxyphenyl) sulfone to a 3000ml three necked flask. 306g (one mol), Chlorobenzene 1000ml and sulfolane 450ml are added and stirred. To the bottom of nitrogen-gas-atmosphere mind, heat at 60 degrees C and 250.5g of NaOH (45 % of the weight) solutions is added gradually. 50ml purified water is added, if heating is continued to the temperature of 120-140 degrees C and a reactant amounts to 145 degrees C except for chlorobenzene with azeotropy, it will cool at 130 degrees C, and it is a screw (4-fluoro phenyl) ketone. 218g is added and it reacts at 200 degrees C for 8 hours. It cooled, and the polymerization reaction object filled the bottom of stirring with a lot of methanols, deposited resin, was filtered, and washed and carried out the vacuum drying with an acetone and warm water. The amount of resin of 450g Repeat unit w:[-(CH<sub>3</sub>) (CH<sub>3</sub>) Ph-SO<sub>2</sub>-Ph(CH<sub>3</sub>) (CH<sub>3</sub>)-O-Ph-CO-Ph-O-] n, glass transition temperature of 240 degrees C. This resin is abbreviated to Resin w.

[0043] [Polymerization:3 which is a polysulfone acid] 4 and 4'-diphenol [ 149 ] and 4 and 4'-dichloro diphenylsulfone 234g, 121.6g [ of anhydrous potassium carbonate ], N, and N'-dimethylacetamide 1200g is taught to a 4000ml three necked flask, the inside of a reactor is made into nitrogen-gas-atmosphere mind, is boiled, and N and N'-dimethylacetamide and water are made to flow out. After performing a polymerization reaction for about 4 hours, it cools, potassium carbonate is carried out a \*\* exception, the bottom of stirring is filled with a lot of methanols, a resin object is deposited, a methanol and warm water wash, and a vacuum drying is performed. The obtained amount of resin is 340g. Glass transition temperature of 220 degrees C. this resin -- a repeat unit -- said n:(-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-) n it is -- this resin is abbreviated to Resin n.

[0044] [Examples 6-10] It blended with the ratio (weight section) shown in a table 6 about various kinds of polysulfone resin and IIR elastic bodies. After mixing with each raw material powder beforehand, it fabricated in the glass syringe configuration shown in drawing 3 after dynamic vulcanization at the extruder temperature of 180-220 degrees C. In drawing 3 , in a glass syringe and 14, \*\*\*\* and 15 express a hypodermic needle and 16 expresses [ 13 ] \*\*\*\*\*.

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Based on Notice of the Ministry of Health and Welfare No. 442, it examined about the obtained glass syringe. A result is shown in a table 7.

[0045]

[A table 6]

[0046]

[A table 7]

[0047] As polysulfone acid system resin, in this invention, the combination of either of the one or more sort all kinds of polysulfone system resin and either of the one or more sort all kinds of

IIR has [ any one sort and the IIR elastic body of the resin of r, n, w, u, and f ] similarly it. [ repeatedly effective in the above this invention example, although the unit showed the example of the combination which is IIR, BIIR, CIIR, or one sort of DVIIR each ] It consists of combination with either of one sort thru/or all the kinds of either of the polysulfone acids of the one sort a unit is [ sort ] among a-w thru/or all the kinds specifically described above, IIR and BIIR, CIIR, and the DVIIR(s) repeatedly.

[0048] It is shown in the form where the embodiment of this invention was summarized, below.

(1) The polysulfone system resin constituent which comes to contain 95 - 5% of the weight more than per sort of an isobutylene-isoprene copolymerization system elastic body, and 5 - 95% of the weight more than per sort of polysulfone system resin.

(2) the medical application which consists of a polysulfone system resin constituent which comes to carry out 5-40 weight section combination of the polysulfone system resin to the one or more sort 100 weight section of an isobutylene-isoprene copolymerization system elastic body, and drugs -- an appliance -- an implement plug.

(3) the medical application which consists of a polysulfone system resin constituent which comes to carry out 5-30 weight section combination of the polysulfone system resin to the one or more sort 100 weight section of an isobutylene-isoprene copolymerization system elastic body, and drugs -- an appliance -- an implement plug.

(4) the medical application which consists of a polysulfone system resin constituent which comes to carry out 2-100 weight section combination of the one or more sorts of an isobutylene-isoprene copolymerization system elastic body to the one or more sort 100 weight section of polysulfone system resin, and drugs -- an appliance -- an implement.

(5) the medical application which consists of a polysulfone system resin constituent which comes to carry out 5-50 weight section combination of the one or more sorts of an isobutylene-isoprene copolymerization system elastic body to the one or more sort 100 weight section of polysulfone system resin, and drugs -- an appliance -- an implement.

(6) Repeat with IIR and a unit is n (-Ph-SO<sub>2</sub>-Ph-S-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(7) A unit (polysulfone system resin constituent given in -Ph-SO<sub>2</sub>-Ph-O-Ph-C(CH<sub>3</sub>)(CH<sub>3</sub>)-Ph-O-]n above-mentioned [ to which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000] ] (1).) repeatedly with BIIR

(8) Repeat with CIIR and a unit is n (-Ph-SO<sub>2</sub>-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(9) Repeat with BIIR and a unit is n (-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(10) Repeat with CIIR and a unit is n (-CH<sub>3</sub>(CH<sub>3</sub>)Ph-SO<sub>2</sub>-Ph(CH<sub>3</sub>)(CH<sub>3</sub>)-O-Ph-CO-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(11) DVIIR, n (-Ph-SO<sub>2</sub>-Ph-O-) a repeat unit -- [-Ph-SO<sub>2</sub>-Ph-O-Ph-C(CH<sub>3</sub>)(CH<sub>3</sub>)-Ph-O-n -- the polysulfone resin and the repeat unit which are expressed with [however, n means the integer of 1-2000] It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(12) DVIIR and a repeat unit are  $n$  (-Ph-SO<sub>2</sub>-Ph-O-). The polysulfone resin and the repeat unit which are expressed with [however,  $n$  means the integer of 1-2000] are  $n$  (-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however,  $n$  means the integer of 2-2000].

(13) Repeat with DVIIR and a unit is  $n$  (-Ph-SO<sub>2</sub>-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however,  $n$  means the integer of 2-2000].

[Effect of the Invention] the medical application by this invention, and drugs -- an appliance -- an implement does the following effectiveness so.

1) It has the exfoliation of three particles and a rubber fragment, the drug solution leakage, the water repellence, the injection needling resistance, the amount of steam transparency, the gas of a head space, the alkali-proof solution nature, the coefficient of water absorption, and the health nature that was excellent about adsorption of a drug solution which has the high health nature which passes the value of standard of a Japanese pharmacopoeia and which has 2 oxygen transparency barrier nature.

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## TECHNICAL FIELD

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[Industrial Application] the medical application which health nature of this invention is high, for example, uses as instrument ingredients, such as a container, and consists of the suitable new polysulfone system resin constituent for a mothball and this constituent of those contents, and drugs -- an appliance -- it is related with an implement.

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## PRIOR ART

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[Description of the Prior Art] About medical application and the instrument for drugs, the class, the engine performance, quality, the trial item, the examining method, the value of standard, etc. are set to the Pharmaceutical Affairs Law, a Japanese pharmacopoeia, and Notice of the Ministry of Health and Welfare. The product with which the iatrotechnique applied the various values of standard as a want matter to each item, an aforementioned approach, and an aforementioned numeric value further in the ever-advancing time is manufactured like today.

[0003] The transparent raw material used for medical application and drugs is mainly a glass product, and came as an instrument combining the Plastic solid which uses natural rubber as a raw material as an elasticity elastic body for being able to come, and it being alike, for example, sealing. however, recent years -- synthetic resin and synthetic rubber -- medical application and drugs -- an appliance -- it inquires as a raw material of an implement and marketing is also carried out.

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## EFFECT OF THE INVENTION

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[Effect of the Invention] the medical application by this invention, and drugs -- an appliance -- an implement does the following effectiveness so.

1) It has the exfoliation of three particles and a rubber fragment, the drug solution leakage, the water repellence, the injection needling resistance, the amount of steam transparency, the gas of a head space, the alkali-proof solution nature, the coefficient of water absorption, and the health nature that was excellent about adsorption of a drug solution which has the high health nature which passes the value of standard of a Japanese pharmacopoeia and which has 2 oxygen transparency barrier nature.

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## TECHNICAL PROBLEM

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[Problem(s) to be Solved by the Invention] by the way, the medical application and drugs which are conventionally used widely -- an appliance -- there are the following properties and troubles about an implement raw material. Plasticizers, such as stabilizers, such as for example, a tin system added by resin, cadmium, and a zinc salt double salt compound, and dioctyl phthalate, dioctyl adipate, tricresyl phosphate, etc. should elute and pollute a polyvinyl chloride (abbreviated name PVC) in drugs and a drug solution. Environmental destruction may be caused when the resin product other than the PVC raw material monomer remaining in resin is discarded. The product with polyethylene (abbreviated name PE) made [ with a product ] from it because softening temperature is low serves as an instrument which cannot carry out high-pressure steam sterilization. Pasteurization is difficult although high-pressure steam sterilization can do polypropylene (abbreviated name PP). There is a report which denaturalized, made resin transparency and used it as medical-application raw material (JP,3-163144,A, said 3-28246 each number official report). Although PE and PP are comparatively excellent in the permeability-proof over moisture and humidity, gas cutoff nature, such as oxygen and carbon dioxide gas, is bad, and a content drug has the problem oxidized and discolored. As an approach of improving the fault of such PE and PP [ whether ethylene and the saponification object (abbreviated name EVOH) of a vinyl acetate copolymerization component are mixed with PE and PP, and ] or making it the package object which carried out the laminating to PE, PP, and EVOH is proposed (for example, "package film --) practical use thermal-resistance:plastics age of a shaping container and a bottle No. 6 (1992) "high barrier multilayer plastic envelope: Pharmaceutical factory vol.6, No.12 (1986)", "The gas barrier nature container of plastics, the gas barrier nature of plastics, and container shaping approach:hood packaging vol.32-No.3", "high gas barrier nature wrapping : Plastics vol.38, No.5" (1987), The application and the actual condition to "barrier nature resin container : Plastics vol.27, No.5" (1977), "barrier nature composite material and PVDC : KOMPA tech vol.15, No.1" (1987), Barrier resin which functionalizes "packing material : KOMPA tech vol.17, No.6(1989)", The "latest functional wrapping : Industrial ingredient vol.37, No.14(1989)", The trend of the "latest functional container: Since water absorption and hygroscopicity of EVOH are very strong, when humidity and moisture live [ science, industrial vol.61-4 (1987)", etc. ] together at the time of high-pressure steam sterilization etc., it has the fault that gas electric shielding validity, such as oxygen and air, is very weak. Although a glass raw material is a raw material excellent in a heatproof, an acid-proof history, transparency, etc., there is a trouble that the alkali generated from a glass front face and the particle which exfoliates from glass pollute a chemical and a drug solution. There are problems,

such as an offensive odor and formaldehyde generating, from the resin of polyphenylene ether resin (abbreviated name PFE), polyethylene terephthalate (abbreviated name PET), polybutylene terephthalate (abbreviated name PBT), and a polycarbonate (abbreviated name PC). In case natural rubber (abbreviated name NR) and the polyisoprene rubber (abbreviated name IR) of synthetic rubber, butadiene rubber (abbreviated name BR), styrene butadiene rubber (abbreviated name SBR), nitrile rubber (abbreviated name NBR), isobutylene isoprene rubber (abbreviated name IIR), halogenation isobutylene isoprene rubber (BIIR, CIIR), etc. are used for medical application and drugs, they have the trouble that the vulcanizing agent, vulcanization accelerator, and reinforcing agent which vulcanize rubber cause elution, exfoliation, etc., and pollute a chemical and a drug solution. this invention persons have proposed the rubber goods (JP,5-43740,B) which already blended the polyethylene of ultrahigh molecular weight with IR, BR, and SBR, and the rubber goods (JP,4-213347,A) which combined the special vulcanizing agent with IIR. the medical application and drugs using the new raw material with which this invention canceled the fault of elegance conventionally -- an appliance -- the medical application which consists of the new polysulfone system resin constituent and new it which especially health nature is high, it uses for instruments, such as a container, and there are no pollutant elution, exfoliation, etc. to contents for the purpose of offer of an implement, and were suitable for the mothball of contents, and drugs -- an appliance -- it has the intention of an implement.

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## MEANS

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[Means for Solving the Problem] This invention offers the polysulfone system resin constituent which comes to contain an isobutylene-isoprene copolymerization system elastic body and polysulfone system resin as The means for solving a technical problem. As a desirable mode in this invention, the polysulfone system resin constituent which is the mixture or the alloy ghost of one or more sorts of an isobutylene-isoprene copolymerization system elastic body and polysulfone system resin which comes to contain one or more sorts is mentioned especially. moreover -- as the especially desirable mode in this invention -- this polysulfone system resin -- n (-Ph-SO<sub>2</sub>-Ph-S-) The thing which makes it a unit repeatedly [however, for n to mean the integer of 2-1000], or (-Ph-SO<sub>2</sub>-Ph-O-) n what makes it a unit repeatedly [however, for n to mean the integer of 2-1000] -- it comes out and a certain thing is mentioned. the medical application which consists of a polysulfone system resin constituent with which this invention comes to contain the isobutylene-isoprene copolymerization system elastic body and polysulfone system resin of this invention further described above, and drugs -- an appliance -- an implement is offered. A plug is especially mentioned as a desirable mode of the medical application of this invention, and the instrument for drugs. furthermore, the medical application of this invention and drugs -- an appliance -- it is also an especially desirable mode that an implement is a syringe, an infusion set, or a container.

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## OPERATION

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[Function] The isobutylene-isoprene copolymerization system elastic body concerning this invention (it may abbreviate to an IIR elastic body hereafter), It is the generic name of rubber



(BIIR) and isobutylene-isoprene-divinylbenzene copolymerization rubber (abbreviated name DVIIR) for which the bromine was made to react to the rubber (CIIR) and isobutylene-isoprene copolymerization rubber which made chlorine react to isobutylene-isoprene copolymerization rubber (IIR) and isobutylene-isoprene copolymerization rubber, and is the elastic body which comes to vulcanize IIR, CIIR, BIIR, and DVIIR using one or more sorts chosen from a vulcanizing agent, for example, sulfur, a zinc white, magnesium, an amine compound, organic peroxide a MAIMIDO compound,

[0007] the IIR elastic body concerning this invention -- 4.5 or less % of the weight of isoprene radical contents, and average molecular weight 10,000-650,000 it is -- for example, the 100 weight sections of IIR -- receiving Sulfur, for example, t-butylperoxy isopropyl, n-butyl -4, 4'-screw (t-butyl peroxide) valerate, Organic peroxide, such as 1 and 1-JI (t-butylperoxy) 3 and 3 and a 5-trimethyl cyclohexane, For example, maleimide, such as N and N'-m-phenylene bismaleimide A vulcanizing agent and dipentamethylenethiuramtetrasulfide, such as a zinc white, It can manufacture with the well-known means of vulcanizing vulcanization accelerators, such as zinc diethyldithiocarbamate, tetramethylthiurammonosulfide, and tetramethylthiuramdisulfide, 0.5 - 2 weight section, in addition by carrying out heating application of pressure, for example.

[0008] The elastic body of BIIR and CIIR concerning this invention can be manufactured by carrying out 1-5 weight section addition, and heating and pressurizing vulcanizing agents, such as a zinc white and magnesium oxide, for example, the organic amine compound which has an amino group and a carboxyl group in intramolecular, the same vulcanization accelerator as the case of said IIR elastic body, etc. to the 100 weight sections of BIIR and CIIR.

[0009] The elastic body of DVIIR concerning this invention can be manufactured by carrying out 0.5-2 weight section combination, heating and pressurizing the same organic peroxide as the elastic body of IIR, and a case, and vulcanizing it to the DVIIR100 weight section.

[0010] As preparation of vulcanization of the elastic body concerning this invention, and the resin constituent of this invention, and the concrete technique of shaping from this constituent, After performing dynamic vulcanization pressurized and heated at 160-220 degrees C with an internal mixer or a mixed extruding machine after mixing the various above compounding agents beforehand to crude rubber, it can mix to polysulfone resin or mixing, the approach of alloy-izing, or the approach of blending the vulcanization accelerator other than a vulcanizing agent, blending a polysulfone acid further, and carrying out shaping vulcanization within metal mold can be adopted.

[0011] The polysulfone system resin concerning this invention is resin of the super-macromolecule object which used association with an aromatic series system hydrocarbon group and a sulfonyl group (-SO<sub>2</sub>-) as the principal component. A phenyl group and a phenylene group are mentioned as this aromatic hydrocarbon radical. The phenyl group or phenylene group combined with one sulfonyl group has one case and 2-7 things, and when it is the latter, they is a biphenyl radical, a bis-phenyl alkane radical, a triphenyl radical, etc. Moreover, the polysulfone system resin of this invention can have low-grade alkyl groups other than a phenyl group, a phenylene group, or a sulfonyl group, such as an oxy-radical (-O-), a thio radical (-S-), a carbonyl group (-CO-), and a methyl group, as a constituent.

[0012] The example of the repeat unit of the polysulfone system resin concerning this invention is given to below. In the following example a-w, a code means as follows. Ph: -- phenyl group or phenylene group, and -SO<sub>2</sub>-: -- a sulfonyl group, a -O-:oxy-radical, a -S-:thio radical, a -CO-:carbonyl group, and a CH<sub>3</sub>-:methyl group. n: Integer a of 2-1000 : (-Ph-SO<sub>2</sub>)-nb:(-Ph-SO<sub>2</sub>-

Ph-)nc:(-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph)nd:(-Ph-SO<sub>2</sub>-Ph-Ph-Ph-SO<sub>2</sub>-Ph)ne:(-Ph-SO<sub>2</sub>-Ph-Ph-Ph-SO<sub>2</sub>-)nf:(-Ph-SO<sub>2</sub>-Ph-O-)ng:(-Ph-SO<sub>2</sub>-Ph-SO<sub>2</sub>-Ph-O-)nh:(-Ph-SO<sub>2</sub>-Ph-SO<sub>2</sub>-Ph-O-Ph-O-)ni:(-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph-O-)nj:(-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph-O-Ph-O-)nk:(-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-)nl:(-Ph-SO<sub>2</sub>-Ph-Ph-O-Ph-O-)nm : () [-Ph-SO<sub>2</sub>] - Ph-O-Ph-O-Ph-O-nn:(-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-)no:(-Ph-SO<sub>2</sub>-Ph-CH<sub>2</sub>-Ph-SO<sub>2</sub>-Ph-O-)np:[-Ph-SO<sub>2</sub>-Ph-Ph-O-Ph-C () [CH<sub>3</sub>] -Ph-O-]nq:[-Ph-SO<sub>2</sub> (CH<sub>3</sub>) - Ph-O-Ph-C(Ph) (Ph)-Ph-O-]nr:(-Ph-SO<sub>2</sub>-Ph-S-)ns:(-Ph-SO<sub>2</sub>-Ph-O-Ph-CO-Ph-O-)nt:(-Ph-SO<sub>2</sub>-Ph-O-Ph-O-)nu:[-Ph-SO<sub>2</sub> - Ph-O-Ph-C(CH<sub>3</sub>) (CH<sub>3</sub>)-Ph-O-:] [nv:(-Ph-Ph-SO<sub>2</sub>-Ph-Ph-SO<sub>2</sub>-Ph-O-)nw] [-(CH<sub>3</sub>) (CH<sub>3</sub>)-Ph-SO<sub>2</sub>-Ph(CH<sub>3</sub>) (CH<sub>3</sub>)-O-Ph-CO-Ph-O-] n [0013] The polysulfone system resin concerning this invention is a polymer which uses as a principal component a repeat unit which was described above. A conventionally well-known technique, for example, JP,45-21318,B -- said -- 46-21458 -- said -- 47-617 -- said -- 53-25879 -- said -- 56-2091 -- said -- 61-12930 and JP,52-96700,A -- said -- 53-10696 -- said -- 59-12930 -- said -- 63-21030 -- said -- 63-243128 -- JP,1-315422,A -- said -- 1-318040 -- said -- 3-41120 -- said -- 3-95200 -- said -- the technique indicated by 4-335030, said 5-9453 each number official report, etc. A polymerization is carried out and it can manufacture. average molecular weight of this polysulfone system resin 5,000-950,000 it is -- many carrying-out [ using an alkaline catalyst ]-in polar organic solvent-polymerization of this resin approaches are adopted. However, as for the polysulfone system resin used for this invention, what repeated solvent washing, warm water washing, etc. and removed a raw material compound, the oligomer of low molecular weight, an inorganic compound (many are NaCl), etc. as much as possible is desirable. Various kinds of well-known techniques are applicable to the purification means of such this polysulfone system resin. It is tough nature, high intensity, thermal resistance, KUREBU-proof nature, and abrasion resistance, and the polysulfone acid system resin concerning this invention is resin of a frank color and transparency, it has the resistance excellent also in an acid, alkali, and salting in liquid, and can also bear the high temperature service in the inside of a detergent and a hydrocarbon. furthermore -- since it has the property that it can be repeatedly equal also to 130 degrees C and the autoclave sterilization for 30 minutes with steam-proof and hot water resistance -- medical application and drugs -- an appliance -- it uses for an implement and is dramatically advantageous.

[0014] In addition, what added the stabilizer of the amount of macromolecules comparatively as polysulfone acid resin of this invention is desirable. As such a stabilizer \*\*, for example, tetrakis [methylene (3, 5-G t-butyl-4-hydroxyphenyl) propionate] methane, : Trade name IRUGA NOx 1010 (Ciba-Geigy make), Triethylene glycol-bis--3-(2-t-butyl-4-hydroxy-5-methylphenyl) propionate : Trade name IRUGA NOx 245 (Ciba-Geigy make), Screw (2, 6-G t-butyl-4-methylphenyl) PENTA ERIS toll diphosphite : Trade name ADEO stub PEP-36 (product made from Asahi Electrification), It is desirable for N and N'-m-phenylene bismaleimide, a tocopherol, etc. to be mentioned and to carry out 0.01-0.5 weight section addition of these one or more kinds to this polysulfone acid resin 100 weight section.

[0015] The constituent of this invention comes to contain the above-mentioned IIR elastic body and polysulfone system resin. Moreover, this IIR elastic body and polysulfone system resin can also blend one or more sorts respectively. Polysulfone acid system resin is preferably blended in 95 - 5% of the weight of the range 99 to 1% of the weight to an IIR elastic body. this blending ratio of coal -- medical application and drugs -- an appliance -- it is desirable to choose corresponding to the class of implement and the hard and soft degree suitable for that instrument. For example, when applying as an instrument plug for medical application and drugs, it is desirable to carry out 5-40 weight section combination of the polysulfone acid system resin to

the IIR elastic body 100 weight section. It is 5 - 30 weight section especially preferably. This is because the physical characteristic as a plug, for example, the physical characteristic needed in the case of injection needling, will be lacked under in 5 weight sections when it cannot acquire to the desired end, suitable property, for example, elasticity, but 40 weight sections are exceeded. moreover, medical application and drugs -- an appliance -- the elastic body chosen from BIIR, CIIR, and DVIIR to the polysulfone acid 100 weight section when using it for the body of a container of an implement etc. -- the 2 - 100 weight section -- desirable -- 5 - 50 weight section -- mixing -- or it alloy-izes. the resin object of thermal resistance and high elasticity -- becoming -- a medical-application instrument and drugs -- an appliance -- as an implement, thermal resistance is high, therefore serves as the container and instrument which repeat heat sterilization, high voltage auto KUREBU sterilization, and ethyleneoxide sterilization, and can perform them. Therefore, it fabricates and is suitable for the instrument for an operation, a syringe, a syringe-cum-a container, etc. Moreover, it could be made the film, and could use for raw materials, such as bags for infusion solutions, and it became clear that it could use suitable for the preservation container of the high TARORI transfusions containing grape sugar and amino acid etc. In this film shaping, it is desirable to mix processing aid, a graft copolymer, etc. to the constituent of this invention.

[0016] The constituent which consists of the IIR elastic body and polysulfone resin of this invention as mentioned above may be mixture, and can also be made into an alloy ghost. Moreover, processing aid can be added in order to make the workability of mixture and an alloy ghost, and a moldability good. As such processing aid, for example Higher-fatty-acids:, for example, arachin acid, Metal soap:, for example, zinc stearate, calcium stearates, such as behenic acid, Fatty-acid amides:, for example, styrene bis-stearyl amides, such as an aluminum stearate salt, Ethylene bis-oleic amide, a behenic acid amide, octadecanamide, etc., Higher-fatty-acid ester:, for example, long-chain-fatty-acid ester of 20-24 carbon numbers, Wax:, for example, a micro crystallin wax, such as a sorbitan fatty acid ester The amount polyethylene of giant molecules, alcohols of 16-18 carbon numbers, such as polyethylene wax, One or more kinds, such as silicone oils, below 10 weight sections, a graft copolymer, a block copolymer (for example, the hydrogenation object of a styrene-butadiene-rubber-block copolymer and this copolymer --) a poly dimethylsiloxane-polyethylene oxide block copolymer, an ethylene-glycidyl methacrylate graft copolymer, etc. -- etc. -- from -- blending one or more kinds chosen below 20 weight sections It can consider as a very uniform alloy ghost, and workability can be improved.

[0017] As a means to mix and knead the IIR elastic body and polysulfone system resin concerning this invention, and to alloy-ize them, conventionally, using well-known equipment, for example, an internal mixer, one shaft, or a twin screw extruder, it can carry out at the temperature of 120-380 degrees C, and becomes uniform mixture and an alloy ghost. moreover -- as it is -- extrusion molding -- carrying out -- medical application and drugs -- an appliance -- it can also consider as an implement. the medical application concerning this invention, and drugs - - an appliance -- the product fabricated as an implement -- each -- 48. test for rubber closure for aqueous infusions of a Japanese pharmacopoeia (the 12th amendment), the plastic envelope examining method for 49. infusion solutions, and Notice of the Ministry of Health and Welfare No. 301 -- said -- No. 413 -- said -- the medical application which suits No. 442, and drugs -- an appliance -- it is an implement and can consider as a syringe, a syringe-cum-a container, and an infusion set instrument. Moreover, it becomes drugs and the container which has the outstanding

description that the quality can be held for a content chemical over a long period of time as a container of a drug solution.

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## EXAMPLE

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[Example] Hereafter, although an example explains this invention to a detail, this invention is not limited to these.

[Polymerization:1 which is the Pol sulfonic acid] NaHS(47 % of the weight of concentration) 358g, NaOH(48 % of the weight of concentration) 225g, CH<sub>3</sub> COONa123g, Na<sub>2</sub> CO<sub>3</sub> 19g, and N-methyl pyrrolidone 2376g are taught to a 10,000ml autoclave, and it agitates at the temperature of 130 degrees C for 3 hours, passing nitrogen gas. After cooling the mixture at 70 degrees C, it mixes agitating N-methyl pyrrolidones 297g and 4 and 4-dichloro diphenylsulfone 878.5g mixture in this reactant, it heats at the temperature of 260 degrees C for 4 hours, and a polymerization is performed. next -- while cooling agitating to 120 degrees C with 1-degree-C speed for /and agitating in 9g [ of acetic acids ], and N-methyl pyrrolidone 2583g -- gradual -- slushing -- a polymer -- a particle -- after making it deposit as powdered and carrying out a \*\* exception -- 1500ml of 70-degree C warm water -- washing -- it washes in methanol 1000ml further. It is IRUGA NOx 1010 to the obtained polymer 100 weight section. It dries in a vacuum after adding the 0.1 weight sections. It was the amount of resin of 632g and glass transition temperature of 192 degrees C which were obtained. The repeat unit of this resin was n (-Ph-SO<sub>2</sub>-Ph-S-) r, i.e., the above mentioned repeat unit, in light yellow transparence. This resin is abbreviated to Resin r.

[0019] The [examples 1-3 and the example 1 of a comparison, and 2] IIR[trade name The 2.0-mol % and ML1+8 100 \*\* 42]100 weight section is received whenever [ JSR Butyl 365, Japan Synthetic Rubber Co., Ltd. make, and partial saturation ]. the ratio (the section in a table means the weight section) which shows polysulfone resin r obtained above in the following table 1 -- blending -- an internal mixer and a twin screw extruder -- kneading -- 2 rolls -- \*\*\*\*(ing) -- combination -- the ground was created.

[0020]

[A table 1]

[0021] \*\* of the above-mentioned table 1 - \*\* are as follows.

\*\* PE : low density polyethylene, show REXX M222, the Showa Denko K.K. make, 92 degrees C of softening temperatures.

\*\* Bulking agent : trade name Whitetex:Southern Product made from Clay.

\*\* 2, the 5-dimethyl -2, 5-JI (t-butylperoxy) hexane.

\*\* N and N'-m-phenylene bismaleimide.

\*\* Micro crystallin wax (melting point of 110 degrees F, NIPPON SEIRO CO., LTD. make).

\*\* gamma-mercaptoptrimethoxysilane : Nippon Unicar make A-189 (trade name).

[0022] the combination obtained above -- the ground with an oscillating disk rheometer (O. it being called R.R. for short) testing machine Society of Rubber Industry, Japan -- VOL.40 (1967) -- p874 and ASTM D-2705 and SRIS 3102 A minute angle oscillation (torsional oscillation) of an oscillating-type vulcanization trial [revolution reciprocating motion is given. the -- corresponding -- stress -- torque value -- \*\*\*\*\* -- measuring -- torque -- a peak price -- (-- c --) -- asking -- this -- torque -- the minimum value -- (-- b --) -- a difference -- asking -- ] -- carrying out -- the result -- a table 2 -- collecting -- being shown .

[0023]

[A table 2]

[0024] Since an example 1 has the difference of torque value [(c)-(b)] larger than the ground of the example 1 of a comparison, and the example 2 of a comparison and hardness is also large as shown in a table 2, it turns out that rubber is a high elasticity object. Moreover, in the example 2 which increased the quantity of Resin A, and the example 3 which added the silane coupling agent, the addition effectiveness shows torque value higher than an example 1 and Hs value, respectively.

[0025] next, it obtained above -- each -- the rubber stopper for drugs shown in drawing 1 was fabricated by the vulcanization condition:temperature of 170 degrees C, and : during 10 minutes using the ground. In addition, a carboy 2 is capped with a rubber stopper 1, the condition that the aluminium cap 4 wound and fastened is shown, in 3, drawing 1 is the outline sectional view of one example which applied this rubber stopper to the carboy, and, as for drugs and 5, 7 shows [ needle admission into a club and 6 show a head space, and ] a hypodermic needle. The special health trial which the examining methods and this invention persons of the 12th amendment Japanese pharmacopoeia are using about each rubber stopper was performed. The result is shown in a table 3 and a table 4. A special health trial is performed as follows.

[0026] The other special amounts of health trial particles (trial of the particle weight generated from a rubber stopper); ten rubber stoppers are put in into a hard-glass bottle, it vibrates on a package with a film and 300ml of non-\*\*\*\* and container opening are vibrated for 20 seconds with 2 revolutions-per-second extent by hand. After putting after that for 1 hour, the number of an underwater particle is measured with an optical electric shielding mold automatic particle measuring instrument (product made from HIAC). In addition, since existence of the particle 5 micrometers or more in a parenteral solution causes the problem of blockading a blood vessel, it serves as a critical item.

[0027] Exfoliation of a rubber fragment (Fragmentation); 5ml of water is put into the bottle (10ml capacity) of the configuration shown in drawing 1 as 2, a rubber stopper 1 is capped, and then an aluminium cap 4 is rolled and fastened. 2ml water is put into the glass syringe which attached the trial needle [22G (0.70x32mm)], and the needle admission into a club 5 of a rubber stopper is made to penetrate this 20 times. A hypodermic needle is drawn out after pouring in the water in a glass syringe into a bottle at the time of the 20th penetration. After vibrating the inside of a bottle, a rubber stopper is removed, content liquid is filtered and the rubber piece number on a filter paper is counted. Although an exam method is what improved the approach of the British standard 3263 (it abbreviates to BS) and the specification of BS is three or less rubber pieces, less than two pieces are demanded in this current this industry.

[0028] Drug solution leakage; 500ml of water is put into the bottle 2 of drawing 1, a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened. Leave it for 1 hour, running through with the rocket needle 7 (the JMS nature No. 200, rocket needle with an infusion set) from the needle admission into a club 5 of the rubber stopper after heating this for 30 minutes at 121 degrees C within a container, and maintaining a bottle at a handstand condition, then stab with a vent wire, 400ml of water in a bottle is made to flow out, the liquid spill at drawing and this time (ml) is observed for the rocket needle from a rubber stopper at this event, and it measures.

[0029] Water repellence (Water repellency); 500ml of distilled water is put into the bottle 2 of drawing 1, a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened. Next, a bottle wall is observed, after putting into a proof-pressure heating container, steaming for 30 minutes at the temperature of 121 degrees C and leaving it in a room temperature for 24 hours. What does not accept waterdrop at this time is considered as acceptance.

[0030] Injection needling resistance-force trial (Determination of penetrability); the force in case a hypodermic needle 7 (21. the S.W.G. outer diameter of 0.81mm, die length of 38mm) penetrates a rubber stopper the rate for 20cm/is measured with a measurement machine (tension form spreading tension testing machine), and it considers as acceptance by 0.5 kg. An exam is amelioration of the trial to which BS is equivalent. BS value of standard passes by 1000g or less.

[0031] 8ml of brine solutions is put in 2% of the weight into the carboy of the steam permeability test chart 1, a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened further. Change of weight is measured after preservation for six months at a room temperature in the desiccator into which silica gel was put for this glass bottle, and the amount of steam transparency of a rubber stopper (g) is measured. The five averages are taken and 1g or less is considered as acceptance. It is this invention persons' independence specification testing.

[0032] 8ml of brine solutions is put in 2% of the weight into the carboy 2 of gas-constituents trial drawing 1 in a head space, a rubber stopper 1 is capped, and an aluminium cap 4 is rolled and fastened further. It is left for about 10 hours, after carrying out steamy heating of this carboy for 60 minutes at the temperature of 121\*\*1 degree C with a proof-pressure container. Next, gas 5ml

of the head space 6 in a bottle is extracted in the syringe for gas, and this is measured in gas chromatography. Column: See the existence of the peak of a part for 101 (180-200 mesh WHP) and carrier gas helium 50ml/, and 10%OV-temperature [ column / of 100-200 degrees C (4 degree-C temperature up / A part for //) ] \*\*, and size. An exam is a trial which investigates the ultralow volume generation of gas by the rubber and the compounding agent which have been a problem in recent years.

[0033] Alkali-proof solution trial; ten rubber stoppers are put into an alkali-proof container, and it is sodium carbonate 0.5 of the amount of 10 times of rubber stopper weight. After adding a weight % solution, this rubber stopper is capped, and an aluminium cap is rolled and fastened. Next, steamy heating is carried out for 30 minutes at the temperature of 121 degrees C with a high pressure vessel. Except for the rubber stopper after neglect and cooling, the wavelength of 430nm and the permeability of a 650nm visible region are measured for test fluid in a quartz cell to a room temperature. 95% or more is considered as acceptance. the fundamental trial whose exam examines the relation between rubber and a drug solution -- the rubber goods with low permeability -- adoption -- it is unsuitable.

[0034] Water absorption test; the rubber goods which carried out bridge formation shaping are dried by temperature the ordinary pressure of 105 degrees C for 3 hours. Next, it is the weight (A) after about 1-hour neglect in the desiccator containing a desiccating agent. It weighs precisely. Next, it dips into the purified water of the amount of 10 times of this rubber stopper, and steamy heating is carried out for 30 minutes the temperature of 121\*\*1 degree C within a proof-pressure container as it is. After cooling, only a rubber stopper is left for 30 minutes in a desiccator, surface water is taken, and it is the weight at that time (B). It weighs precisely, and asks for  $((B-A)/A) \times 100$  %), and 2 or less % of the weight is considered as acceptance.

[0035] The adsorption test of a drug solution; nitric-acid iso SORUBITO (the medicine for ischemic heart disease, the melting point of 72 degrees C, product made from Japanese-made medicine) was diluted with the physiological saline, and as 0.040 % of the weight, 3ml of this liquid was put into the 10ml bottle 2 at accuracy, the rubber stopper was capped, the aluminium cap was rolled, and it was left in the state of the handstand in total for 24 hours. This is applied to a high-speed liquid chromatograph (product made from HLPC), the amount of nitric-acid iso SORUBITO is measured and the loss in quantity which adsorbed is obtained. Column: FINEPAK SILC18 (a trade name, Jasco make), a mobile-phase methanol: Water = 7:3 and 1ml [ of the rates of flow ] a part for /, detector UVIDEC100-IV (a trade name, the Jasco make, 220nm)

[0036]

[A table 3]

[0037]  
[A table 4]

[0038] As shown in a table 3 and a table 4, all this invention articles conform to the value of standard of the 12th amendment Japanese pharmacopoeia. In addition to it, it turns out that they are the container which can respond to the newest drugs, and the outstanding rubber stopper

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which can also suit the special independence trial item as an instrument. On the other hand, the product of the examples 1 and 2 of a comparison shows the result which poses a problem in several items, such as pH, a residue on evaporation, and the amount of particles.

[0039] [Example 4] The BIIR(product [ made from EXXON CHEMICAL ], ML1+8 125 degree-C 50, 0.6 % of the weight of bromine contents) 100 weight section, 1.0 weight sections [ made from an active white (Sakai Chemical Industry stock) ], N, and N'-m-phenylene bismaleimide (Kawaguchi Chemical Industry Co., Ltd. make) 2.0 weight section, insoluble sulfur (after mixing the 0.2 weight section made from Japanese Dry distillation with an internal mixer, kneading was performed for 7 minutes at the temperature of 160 degrees C, and it considered as dynamic vulcanizate.) the polysulfone resin (it POLYSULFONE(s) trade name UDEL [ ] --) refined independently the Union Carbide repeat unit -- said u:[-Ph-SO<sub>2</sub>-Ph-O-Ph-C(CH<sub>3</sub>)(CH<sub>3</sub>)-Ph-O-] n N-methyl pyrrolidone : The thing]100 weight section washed twice with the solvent which comes to heat water =1:0.5, The ethylene bis-octadecanamide (Nippon Kasei Chemical Co., Ltd. make) 1 weight section, It is the maleic-anhydride 5 weight section about a styrene-butadiene-ethylene copolymer. The block-copolymer (prototype) 5 weight section was made into the alloy ghost at the temperature of 160-220 degrees C with the internal mixer and the 2 ream type extruder. Next, it considered as the uniform film plate through T Thailand. 0.4mm in thickness JIS the place which are the tensile strength of 213kg/cm<sup>2</sup>, and 210% of elongation, and measured the amount of oxygen gas transparency as a result of measuring a physical property based on K6301 (product made from Yanamoto factory GTR) -- the temperature of 20 degrees C, and dryness -- 100cc/m ] 2 and 24 hrs/atm it was . the amount of oxygen gas transparency of the film plate which BIIR before kneading vulcanized -- 300 cc/m<sup>2</sup> and 24 hrs/atm it was -- according to this invention, by mixing polysulfone resin with an IIR elastic body shows from things that the gas barrier nature to oxygen was improved. In addition, the trial based on the plastic envelope examining method for 49. infusion solutions of the 12th amendment Japanese pharmacopoeia about the alloy ghost of BIIR of this invention and polysulfone acid resin is performed, and the result is shown in the after-mentioned table 5.

[0040] [Example 5] After mixing the CIIR(JSR CHLOROBUTYL 1068, trade name, Japan Synthetic Rubber Co., Ltd. make, ML1+8 125 degree-C 50, 1.2 % of the weight of halogen contents) 100 weight section, the active white (Sakai Chemical Industry Co., Ltd. make) 1.0 weight section, and the zinc-diethyldithiocarbamate 1.0 weight section with an internal mixer, kneading was performed for 7 minutes at the temperature of 160 degrees C, and it considered as dynamic vulcanizate. Polysulfone acid [trade name VICTREX PES, the product made from ICI which were refined independently, A repeat unit is said f:(-Ph-SO<sub>2</sub>-Ph-O-) n. A thing tetrahydrofuran: -- water: -- the thing]400 weight section further washed with the acetone after washing with the solvent which acetic-acid =20:5:0.1 heated -- The styrene-ethylene-styrene block-copolymer (Shilu chemical company treatment article) 10 weight section, The polyethylene terephthalate (polyethylene terephthalate [ by Kuraray Co., Ltd. ], grade KS700) 30 weight section was made into the alloy ghost at the temperature of 160-220 degrees C with the internal mixer and the 2 ream type extruder. Next, it considered as the uniform film plate with a thickness of 0.4mm through T Thailand. this film -- JIS physical based on K6301 -- the place which are the tensile strength of 256kg/cm<sup>2</sup>, and 180% of elongation, and measured the amount of oxygen gas transparency like the example 4 as a result of measuring a characteristic -- 85 cc/m<sup>2</sup> and 24 hrs/atm it was . The created transfusions container is shown in drawing 2 . In drawing 2 , in the container regio oralis and 10, a joining plug and 11 express a heat welding and 12 expresses [ 8 / a parenteral solution and 9 ] \*\*\*\*\*. In addition, the trial based on the plastic

envelope examining method for 49. infusion solutions of the 12th amendment Japanese pharmacopoeia is performed, and the result is united and shown in the after-mentioned table 5. As shown in a table 5, the product by this invention has passed the value of standard of the 12th amendment Japanese pharmacopoeia.

[0041]

[A table 5]

[0042] [Polymerization:2 which is a polysulfone acid] It is a screw (3, 5-dimethyl-4-hydroxyphenyl) sulfone to a 3000ml three necked flask. 306g (one mol), Chlorobenzene 1000ml and sulfolane 450ml are added and stirred. To the bottom of nitrogen-gas-atmosphere mind, heat at 60 degrees C and 250.5g of NaOH (45 % of the weight) solutions is added gradually. 50ml purified water is added, if heating is continued to the temperature of 120-140 degrees C and a reactant amounts to 145 degrees C except for chlorobenzene with azeotropy, it will cool at 130 degrees C, and it is a screw (4-fluoro phenyl) ketone. 218g is added and it reacts at 200 degrees C for 8 hours. It cooled, and the polymerization reaction object filled the bottom of stirring with a lot of methanols, deposited resin, was filtered, and washed and carried out the vacuum drying with an acetone and warm water. The amount of resin of 450g Repeat unit w:[-(CH<sub>3</sub>) (CH<sub>3</sub>) Ph-SO<sub>2</sub>-Ph(CH<sub>3</sub>) (CH<sub>3</sub>)-O-Ph-CO-Ph-O-] n, glass transition temperature of 240 degrees C. This resin is abbreviated to Resin w.

[0043] [Polymerization:3 which is a polysulfone acid] 4 and 4'-diphenol [ 149 ] and 4 and 4'-dichloro diphenylsulfone 234g, 121.6g [ of anhydrous potassium carbonate ], N, and N'-dimethylacetamide 1200g is taught to a 4000ml three necked flask, the inside of a reactor is made into nitrogen-gas-atmosphere mind, is boiled, and N and N'-dimethylacetamide and water are made to flow out. After performing a polymerization reaction for about 4 hours, it cools, potassium carbonate is carried out a \*\* exception, the bottom of stirring is filled with a lot of methanols, a resin object is deposited, a methanol and warm water wash, and a vacuum drying is performed. The obtained amount of resin is 340g. Glass transition temperature of 220 degrees C. this resin -- a repeat unit -- said n:(-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-) n it is -- this resin is abbreviated to

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Resin n.

[0044] [Examples 6-10] It blended with the ratio (weight section) shown in a table 6 about various kinds of polysulfone resin and IIR elastic bodies. After mixing with each raw material powder beforehand, it fabricated in the glass syringe configuration shown in drawing 3 after dynamic vulcanization at the extruder temperature of 180-220 degrees C. In drawing 3, in a glass syringe and 14, \*\*\*\* and 15 express a hypodermic needle and 16 expresses [ 13 ] \*\*\*\*\*. Based on Notice of the Ministry of Health and Welfare No. 442, it examined about the obtained glass syringe. A result is shown in a table 7.

[0045]

[A table 6]

[0046]

[A table 7]

[0047] As polysulfone acid system resin, in this invention, the combination of either of the one or more sort all kinds of polysulfone system resin and either of the one or more sort all kinds of IIR has [ any one sort and the IIR elastic body of the resin of r, n, w, u, and f ] similarly it. [ repeatedly effective in the above this invention example, although the unit showed the example of the combination which is IIR, BIIR, CIIR, or one sort of DVIIR each ] It consists of combination with either of one sort thru/or all the kinds of either of the polysulfone acids of the one sort a unit is [ sort ] among a-w thru/or all the kinds specifically described above, IIR and BIIR, CIIR, and the DVIIR(s) repeatedly.

[0048] It is shown in the form where the embodiment of this invention was summarized, below.

- (1) The polysulfone system resin constituent which comes to contain 95 - 5% of the weight more than per sort of an isobutylene-isoprene copolymerization system elastic body, and 5 - 95% of the weight more than per sort of polysulfone system resin.
- (2) the medical application which consists of a polysulfone system resin constituent which comes to carry out 5-40 weight section combination of the polysulfone system resin to the one or more sort 100 weight section of an isobutylene-isoprene copolymerization system elastic body, and drugs -- an appliance -- an implement plug.
- (3) the medical application which consists of a polysulfone system resin constituent which comes to carry out 5-30 weight section combination of the polysulfone system resin to the one or more sort 100 weight section of an isobutylene-isoprene copolymerization system elastic body, and drugs -- an appliance -- an implement plug.
- (4) the medical application which consists of a polysulfone system resin constituent which comes to carry out 2-100 weight section combination of the one or more sorts of an isobutylene-isoprene copolymerization system elastic body to the one or more sort 100 weight section of polysulfone system resin, and drugs -- an appliance -- an implement.
- (5) the medical application which consists of a polysulfone system resin constituent which comes to carry out 5-50 weight section combination of the one or more sorts of an isobutylene-isoprene copolymerization system elastic body to the one or more sort 100 weight section of polysulfone system resin, and drugs -- an appliance -- an implement.
- (6) Repeat with IIR and a unit is n (-Ph-SO<sub>2</sub>-Ph-S-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].
- (7) A unit (polysulfone system resin constituent given in -Ph-SO<sub>2</sub>-Ph-O-Ph-C(CH<sub>3</sub>)(CH<sub>3</sub>)-Ph-

O-]n above-mentioned [ to which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000] ] (1.) repeatedly with BIIR

(8) Repeat with CIIR and a unit is n (-Ph-SO<sub>2</sub>-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(9) Repeat with BIIR and a unit is n (-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(10) Repeat with CIIR and a unit is n (-(CH<sub>3</sub>) (CH<sub>3</sub>) Ph-SO<sub>2</sub>-Ph(CH<sub>3</sub>) (CH<sub>3</sub>)-O-Ph-CO-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(11) DVIIR, n (-Ph-SO<sub>2</sub>-Ph-O-) a repeat unit -- [-Ph-SO<sub>2</sub>-Ph-O-Ph-C(CH<sub>3</sub>) (CH<sub>3</sub>)-Ph-O-n -- the polysulfone resin and the repeat unit which are expressed with [however, n means the integer of 1-2000] It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 1-2000].

(12) DVIIR and a repeat unit are n (-Ph-SO<sub>2</sub>-Ph-O-). The polysulfone resin and the repeat unit which are expressed with [however, n means the integer of 1-2000] are n (-Ph-SO<sub>2</sub>-Ph-O-Ph-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 2-2000].

(13) Repeat with DVIIR and a unit is n (-Ph-SO<sub>2</sub>-Ph-O-). It is the polysulfone system resin constituent of the above-mentioned (1) publication with which it comes to blend the polysulfone resin expressed with [however, n means the integer of 2-2000].

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## DESCRIPTION OF DRAWINGS

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[Brief Description of the Drawings]

[Drawing 1] It is the outline sectional view showing one example which applied the rubber stopper for drug solutions concerning this invention to the carboy.

[Drawing 2] It is the sectional view of the container for infusion solutions concerning this invention.

[Drawing 3] It is the sectional view of the syringe concerning this invention.

[Description of Notations]

1 A rubber stopper, a parenteral solution, the 9 container regio oralis, a 10 joining plug, a 11 heat welding, 12 \*\*\*\*\*, a 13 glass syringe, 14 \*\*\*\*, a 15 hypodermic needle, 16 \*\*\*\*\*. 2 Carboy  
3 Drugs 4 Aluminum KYUYAPPU 5 Needle admission into a club 6 Head space 7 Hypodermic needle 8